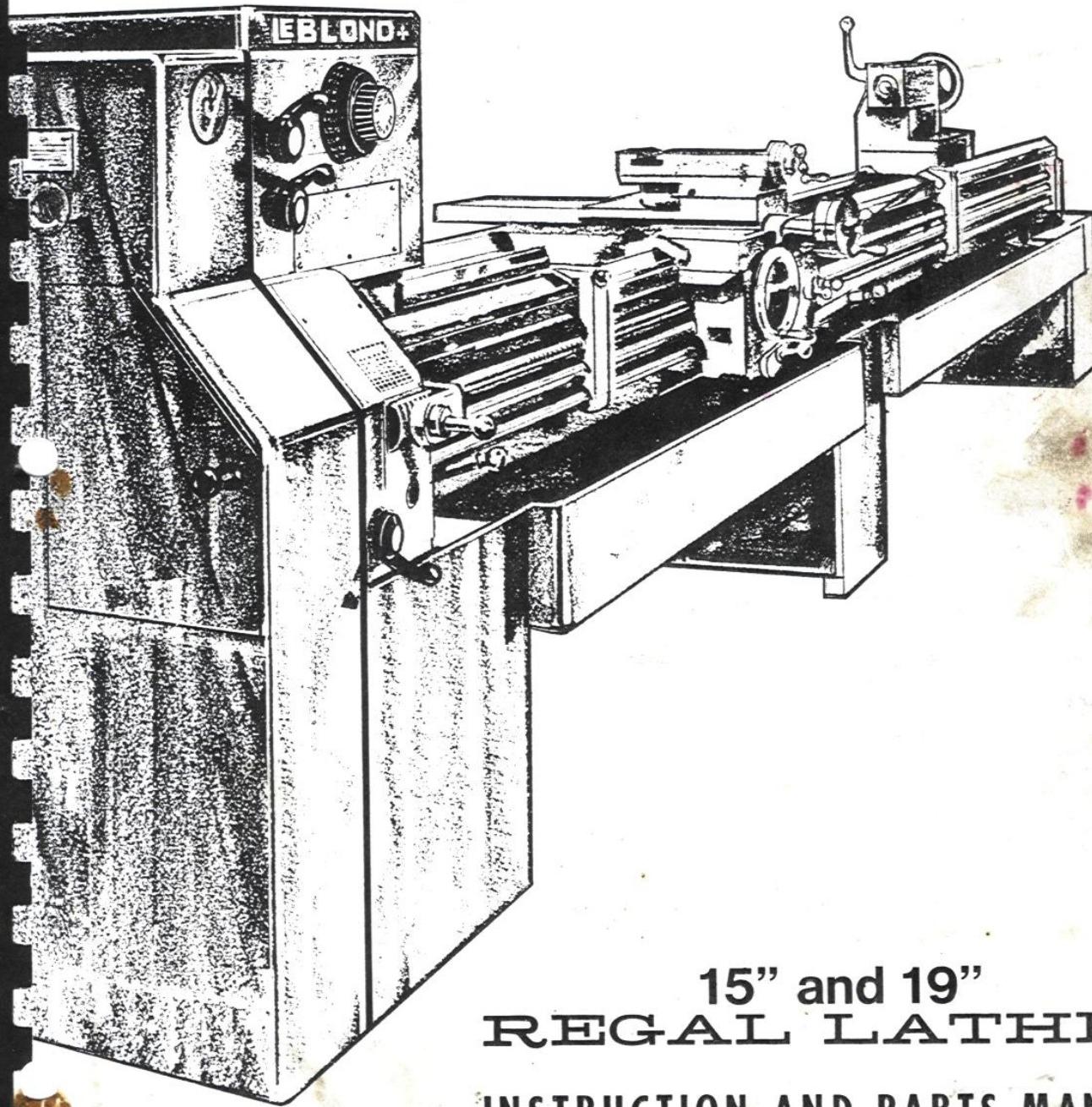




LEBLOND

MACHINE TOOL



15" and 19"
REGAL LATHES

INSTRUCTION AND PARTS MANUAL
MANUAL NO. 3931

INSTRUCTIONS FOR ORDERING PARTS

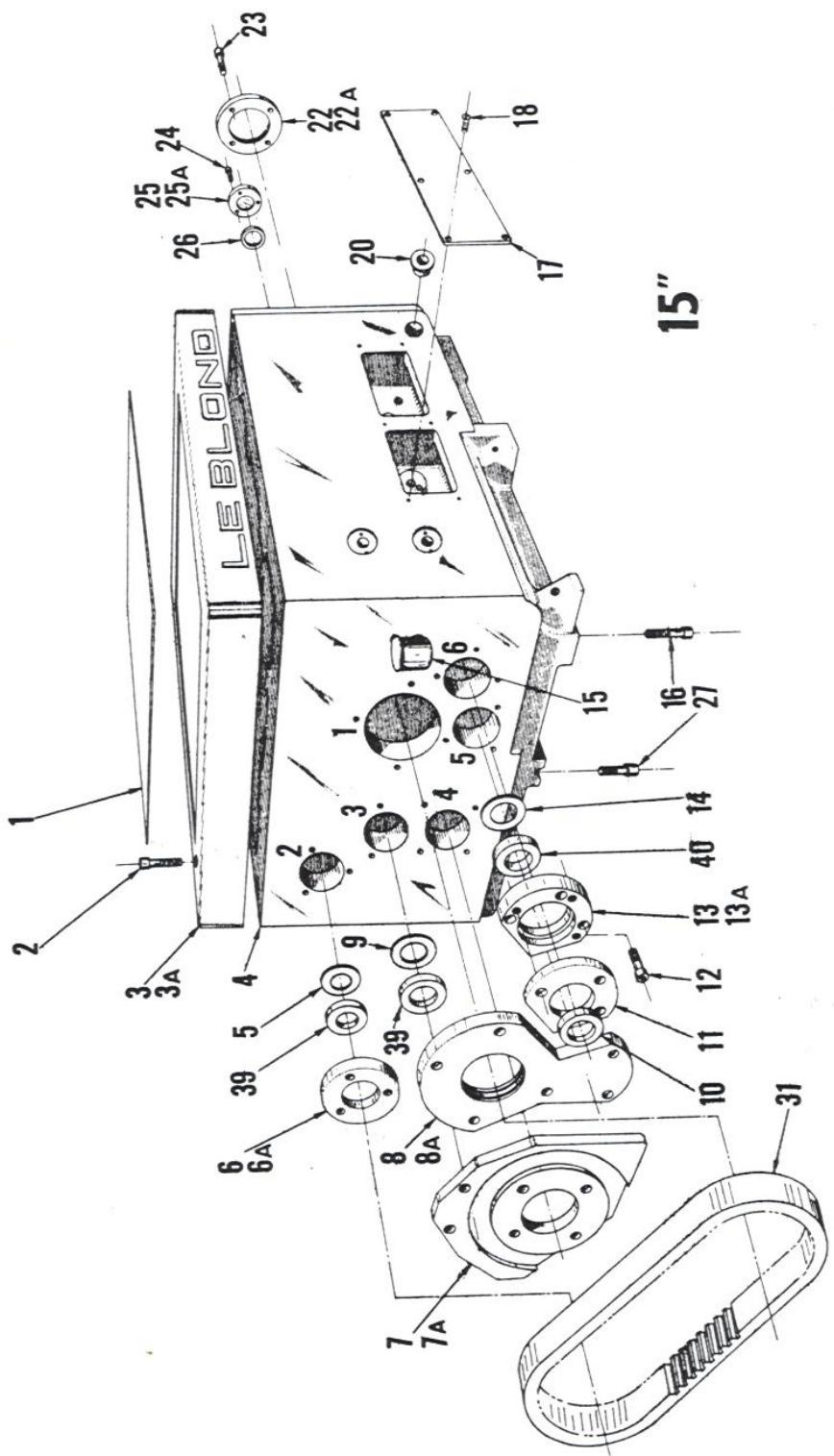
When ordering repair parts, the following information must be given for best service:

1. Serial number of the lathe. This can be found on the front flat bedway at the tailstock end of the bed.
2. The name of the part, the key number of the part, and the page number on which the part appears in the block.

In the Repair Parts Section the 15" Regal is taken as the basic machine in working up the lists. Therefore, some parts on Regals of other sizes will not be identical with the illustrations. This is the reason why we require the Serial No. of your lathes before the proper part can be sent.

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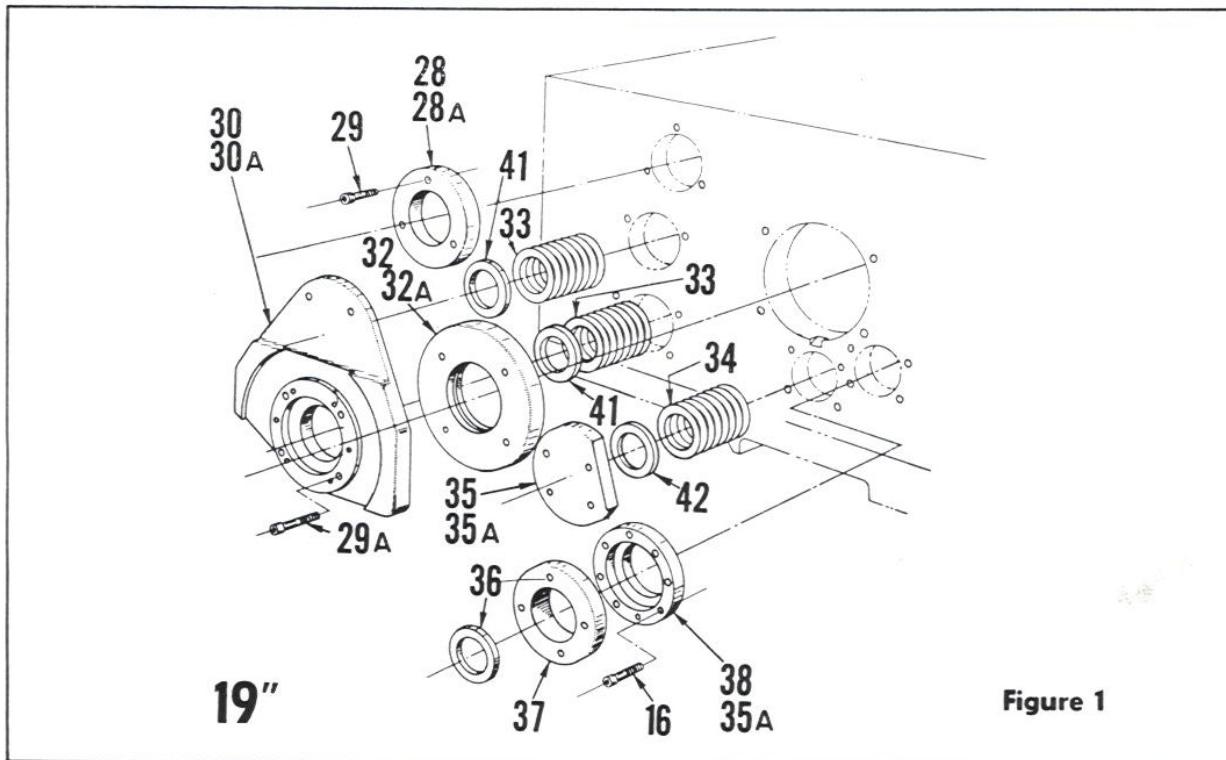


Figure 1

HEADSTOCK CASTING

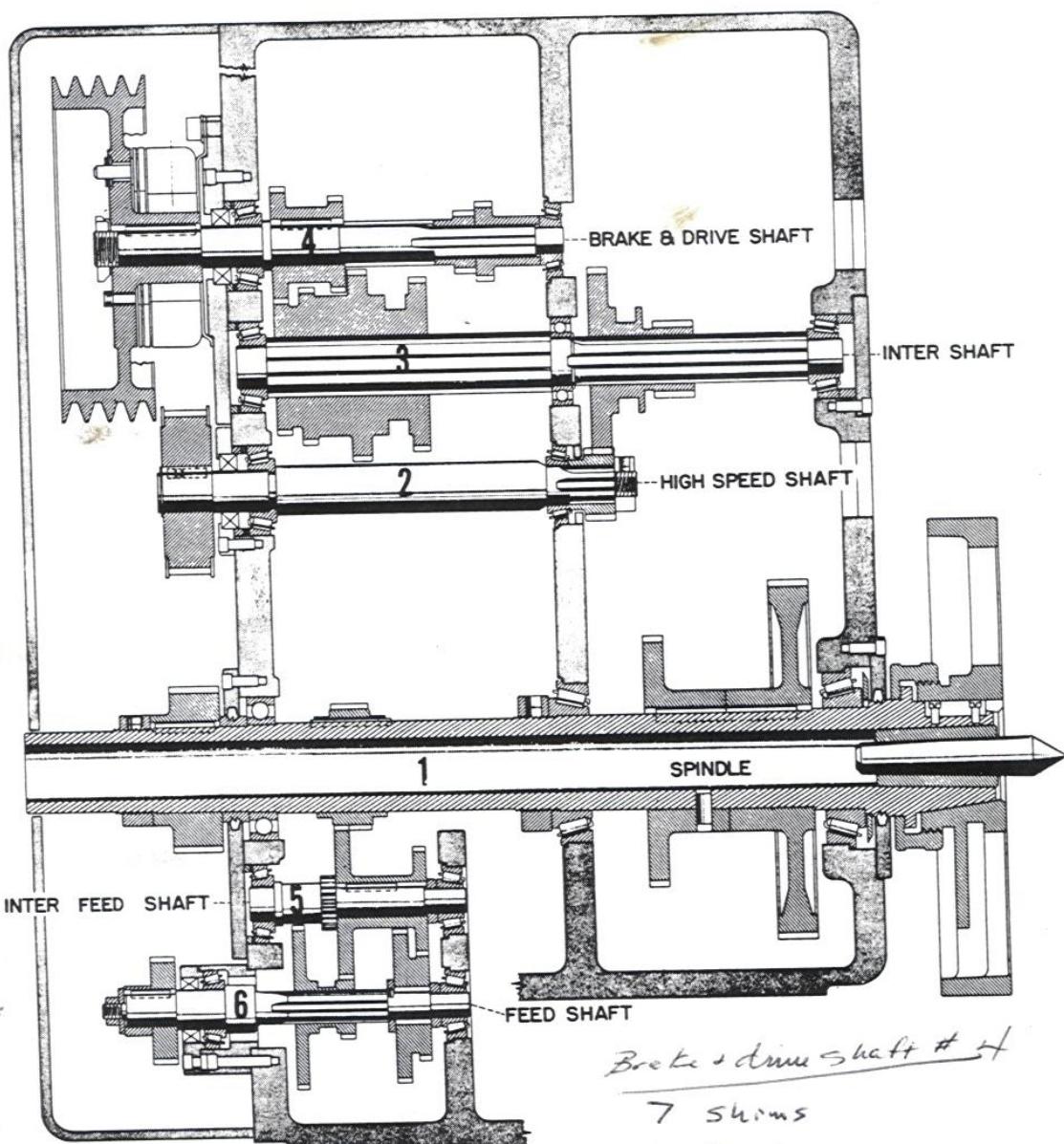
Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
1- 1	Mat, Head Cover	1	1-22	Flange, Spindle Front	1
1- 2	Screw, Socket Head	8	1-22A	Gasket, Spindle Front Flange	1
1- 3	Cover, Head Top	1	1-23	Screw, Socket Head	4
1- 3A	Gasket, Head Cover	1	1-24	Screw, Socket Head	3
1- 4	Head	1	1-25	Plug, Inter. Shaft Front	1
1- 5	Collar, High Speed Shaft Matching.	1	1-25A	Gasket, Inter. Shaft Front	1
1- 6	Flange, High Speed Shaft Rear	1	1-26	Spacer, Inter. Shaft	1
1- 6A	Gasket, High Speed Shaft Flange	1	1-27	Screw	2
1- 7	Flange, Drive Shaft	1	1-28	Flange, High Speed Shaft Rear	1
1- 7A	Gasket, Drive Shaft Flange	1	1-28A	Gasket, High Speed Shaft Flange	1
1- 8	Flange, Spindle Rear	1	1-29	Screw, Socket Head	2
1- 8A	Gasket, Spindle Rear Flange	1	1-30	Flange, Drive Shaft	1
1- 9	Collar, Drive Shaft Matching	2	1-30A	Gasket, Drive Shaft	1
1-10	Seal, Victoprene Oil	1	1-31	Belt, Timing	1
1-11	Cap, Fd. Shaft Brg. Sleeve	1	1-32	Flange, Rear Spindle	1
1-12	Screw, Socket Head	3	1-32A	Gasket, Spindle Rear Flange	1
1-13	Sleeve, Fd. Shaft Brg.	1	1-33	Shim, Drive Shaft Matching	16
1-13A	Gasket, Fd. Shaft Brg. Sleeve	1	1-34	Shim, Inter. Feed Shaft Match	8
1-14	Collar, Interfd. Shaft Matching.	1	1-35	Cover, Inter. Feed Shaft Brg.	1
1-15	Oiler	1	1-35A	Gasket, Feed Shaft Sleeve	3
1-16	Screw	2	1-36	Seal, Victoprene Oil	1
1-17	Cover, Head Front	1	1-37	Cap, Feed Shaft Brg. Sleeve	1
1-18	Screw, Button Hd. Soc. Type	6	1-38	Sleeve, Feed Shaft Bearing	1
1-20	Window Unit, Bijur Oil Level Type	1	1-39	Spacer	2
			1-40	Spacer	1
			1-41	Spacer	2
			1-42	Spacer	1

IMPORTANT—Include serial number of your lathe when ordering repair parts.

#5 Inter Feed shaft
6 Shims
1 Spacer

Feed shaft #6
9 Shims
1 Spacer

Inter shaft #3
1 Spacer



HEADSTOCK ROLLOUT

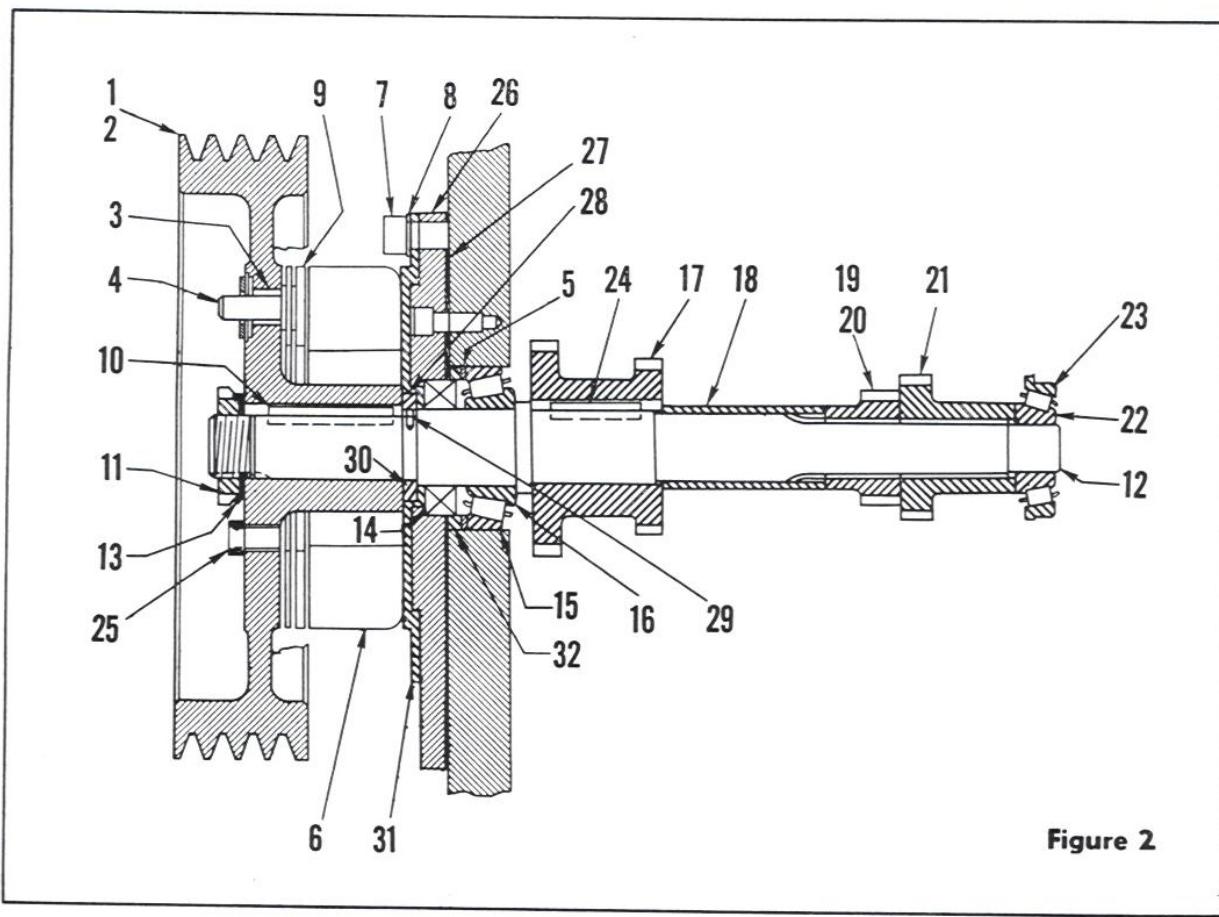


Figure 2

BRAKE & DRIVE SHAFT

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
2- 1	Pulley, Drive	1	2-16	Cone, Timken Bearing #2 15580 .	1
2- 2	Brake, Dyna-Torque	1	2-17	Gear, Drive Shaft Large	1
2- 3	Electric, Outside Mounting	1	2-18	Collar, Drive Shaft Spacing	1
2- 4	Oilite Bushing	3	2-19	Gear, Drive Shaft Small	1
2- 5	Dyna-Torque Accessory Group Including Drive Pins	1	2-20	Key, Flat (not used on 15)	1
2- 6	Spacer, Bearing	1	2-21	Gear, Drive Shaft Inter	1
2- 7	Magnet, 90 Volt	1	2-22	Cone, Timken Bearing #2 05060 .	1
2- 8	Screw	4	2-23	Cup, Timken Bearing #2 05185B .	1
2- 9	Washer	4	2-24	Key, Flat	1
2-10	Armature	1	2-25	Screw	3
2-11	Key, Flat	1	2-26	Flange	1
2-12	Nut, Lock	1	2-27	Gasket	1
2-13	Shaft, Drive	1	2-28	Collar	1
2-14	Washer, Lock	1	2-29	Pin	1
2-15	Seal, Victoprene Oil	1	2-30	Sleeve (19) only	1
	Cup, Timken Bearing #2 15520 .	1	2-31	Mounting Plate	1
			2-32	Spacer	1

IMPORTANT—Include serial number of your lathe when ordering repair parts.

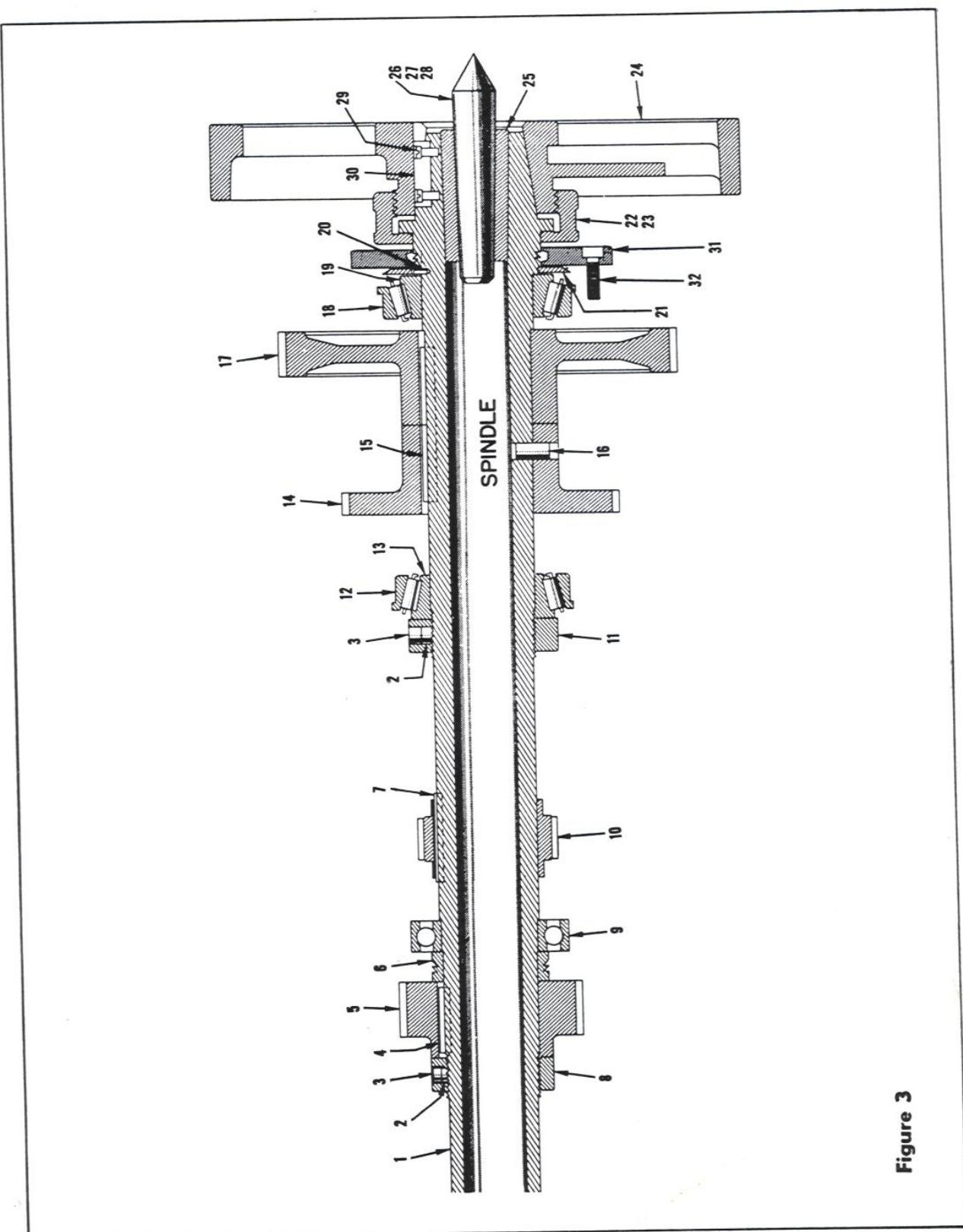


Figure 3

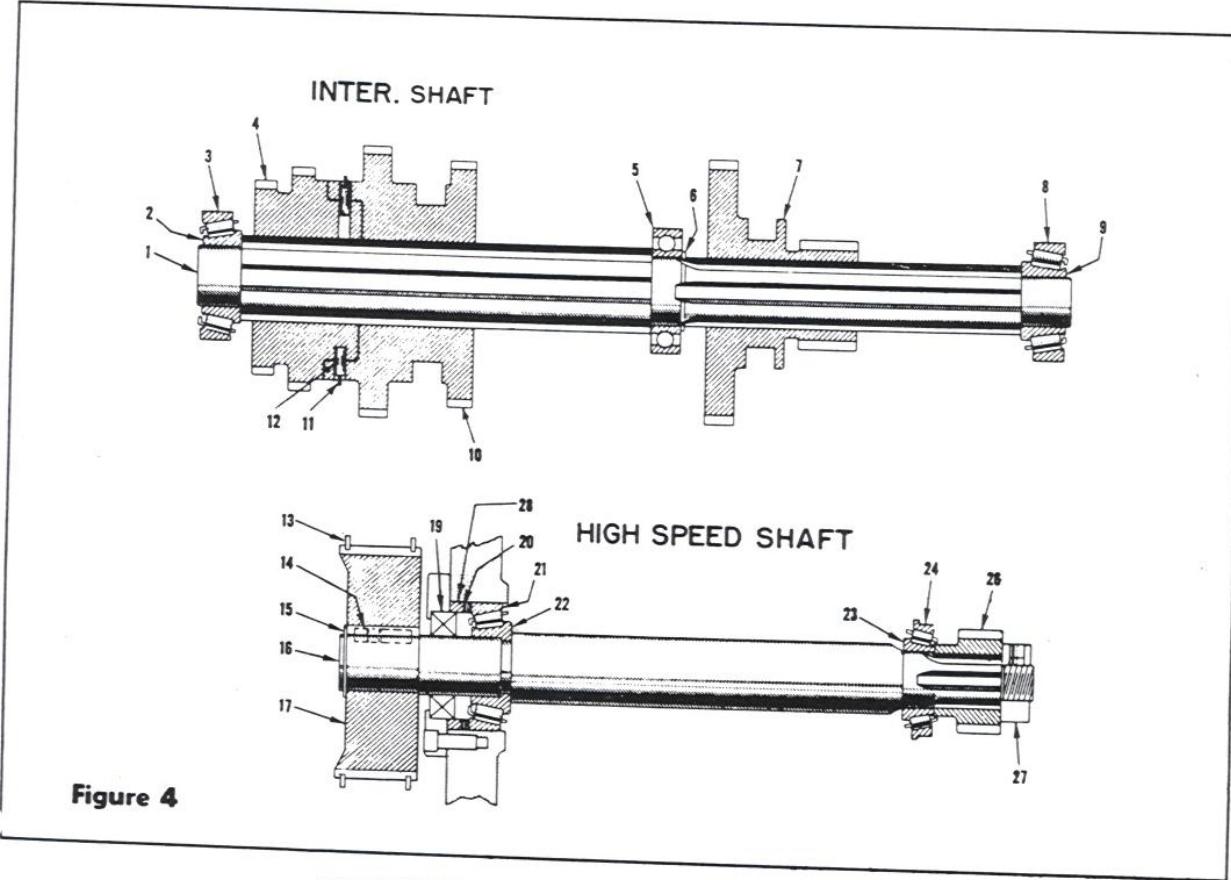


Figure 4

INTERMEDIATE SHAFT-HIGH SPEED SHAFT

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
4- 1	Shaft, Intermediate.	1	4-15	Ring, Truarc	1
4- 2	Cone, Timken Bearing #2 15580	1	4-16	Shaft, High Speed	1
4- 3	Cup, Timken Bearing #2 . 15520	1	4-17	Pulley, High Speed Shaft	1
4- 4	Gear, Intermediate Shaft Cluster	1			
4- 5	Bearing, MRC Ball Japan A.Y. 6000 1 NTN	1	4-19	Seal, Victoprene Oil	1
4- 6	Ring, Truarc	1	4-20	Shim, High Speed Shaft Matching	1
4- 7	Gear, Intermediate.	1	4-21	Cup, Timken Bearing #2 . 15520	1
4- 8	Cup, Timken Bearing #2 . 1328.	1	4-22	Cone, Timken Bearing #2 15580	1
4- 9	Cone, Timken Bearing #2 . 1380.	1	4-23	Cone, Timken Bearing #2 07100	1
4-10	Gear	1	4-24	Cup, Timken Bearing #2 . 07196B	1
4-11	Ring, Snap	1	4-26	Pinion, High Speed Shaft	1
4-12	Pin	2	4-27	Nut, Lock	1
4-13	Ring, High Speed Shaft Pulley	2	4-28	Spacer.	1
4-14	Key, Flat	1			

IMPORTANT—Include serial number of your lathe when ordering repair parts.

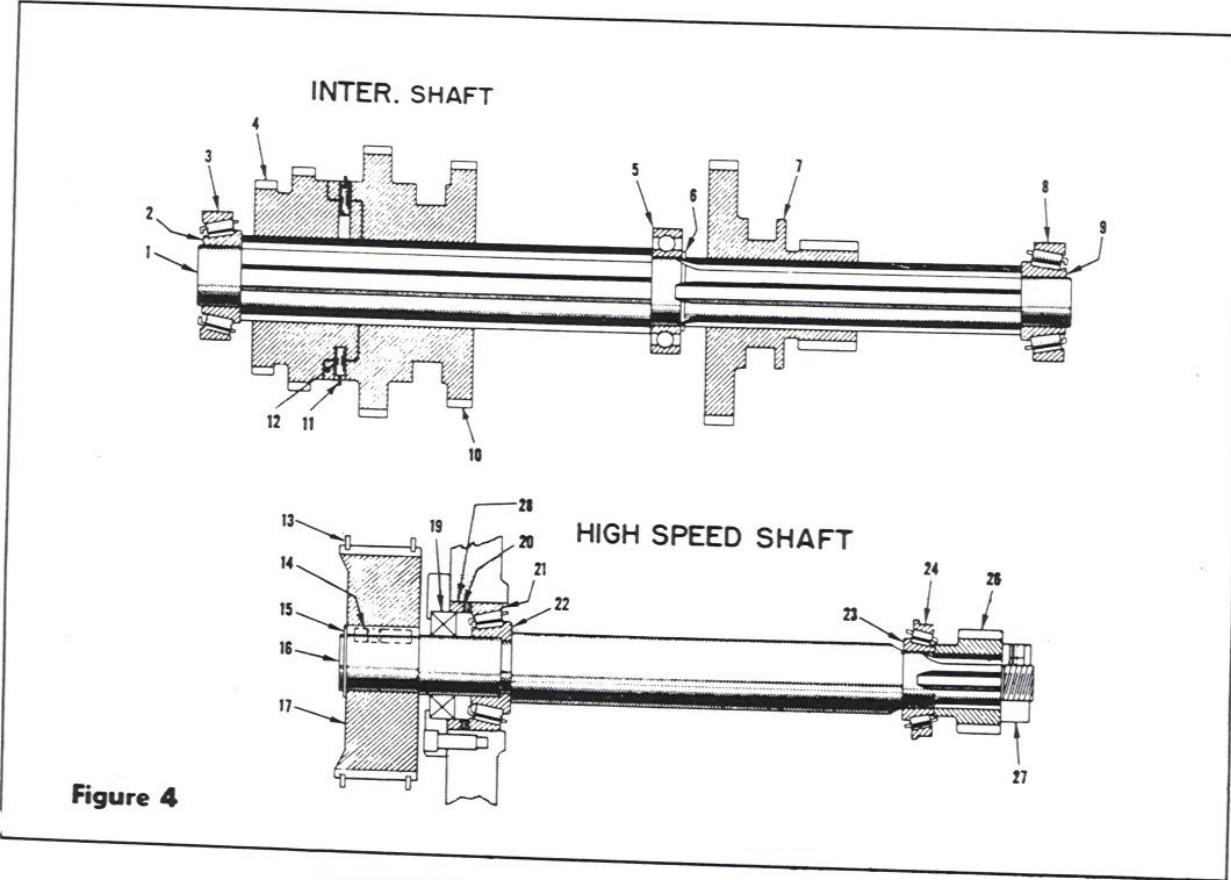


Figure 4

INTERMEDIATE SHAFT-HIGH SPEED SHAFT

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
4- 1	Shaft, Intermediate.	1	4-15	Ring, Truarc	1
4- 2	Cone, Timken Bearing #2 15580	1	4-16	Shaft, High Speed	1
4- 3	Cup, Timken Bearing #2 . 15520	1	4-17	Pulley, High Speed Shaft	1
4- 4	Gear, Intermediate Shaft Cluster	1			
4- 5	Bearing, MRC Ball Japan A.Y. 6000 1 NTN	1	4-19	Seal, Victoprene Oil	1
4- 6	Ring, Truarc	1	4-20	Shim, High Speed Shaft Matching	1
4- 7	Gear, Intermediate.	1	4-21	Cup, Timken Bearing #2 . 15520	1
4- 8	Cup, Timken Bearing #2 . 1328.	1	4-22	Cone, Timken Bearing #2 15580	1
4- 9	Cone, Timken Bearing #2 . 1380.	1	4-23	Cone, Timken Bearing #2 07100	1
4-10	Gear	1	4-24	Cup, Timken Bearing #2 . 07196B	1
4-11	Ring, Snap	1	4-26	Pinion, High Speed Shaft	1
4-12	Pin	2	4-27	Nut, Lock	1
4-13	Ring, High Speed Shaft Pulley	2	4-28	Spacer.	1
4-14	Key, Flat	1			

IMPORTANT—Include serial number of your lathe when ordering repair parts.

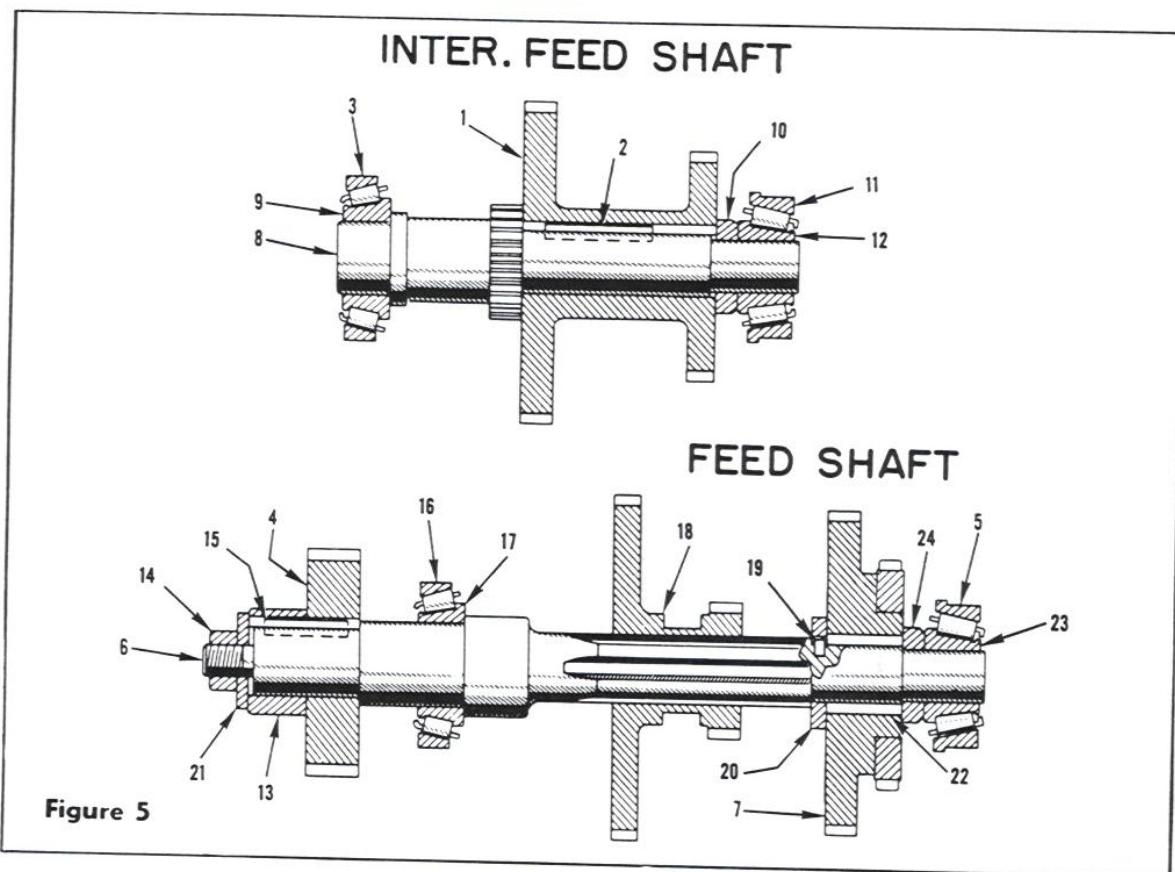


Figure 5

INTERMEDIATE FEED SHAFT- FEED SHAFT

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
5- 1	Gear, Intermediate Feed Shaft . . .	1	5-14	Nut, Hex	1
5- 2	Key, Flat	1	5-15	Key, Flat	1
5- 3	Cup, Timken Bearing #2 07196	1	5-16	Cup, Timken Bearing #2 07196	1
5- 4	Gear, Feed Change	1	5-17	Cone, Timken Bearing #2 07100	1
5- 5	Cup, Timken Bearing #2 17520B	1	5-18	Gear, Feed Shaft Sliding	1
5- 6	Shaft, Feed	1	5-19	Pin, Straight	1
5- 7	Gear, Feed Reverse Idler	1	5-20	Collar, Feed Reverse Idler Gear . . .	1
5- 8	Shaft, Intermediate Feed	1	5-21	Collar, Thrust	1
5- 9	Cone, Timken Bearing #2 07087	1	5-22	Washer, Spec.	1
5-10	Collar, Spacing	1	5-23	Bush, Feed Reverse Idler Gear . . .	1
	Collar, Thrust	1	5-24	Cone, Timken Bearing #2 17580	1
5-11	Cup, Timken Bearing #2 17520-B	1		Collar, Spacing	1
5-12	Cone, Timken Bearing #2 17580	1			
5-13	Collar, Feed Shaft Change Gear . . .	1			

IMPORTANT — Include serial number of your lathe when ordering repair parts

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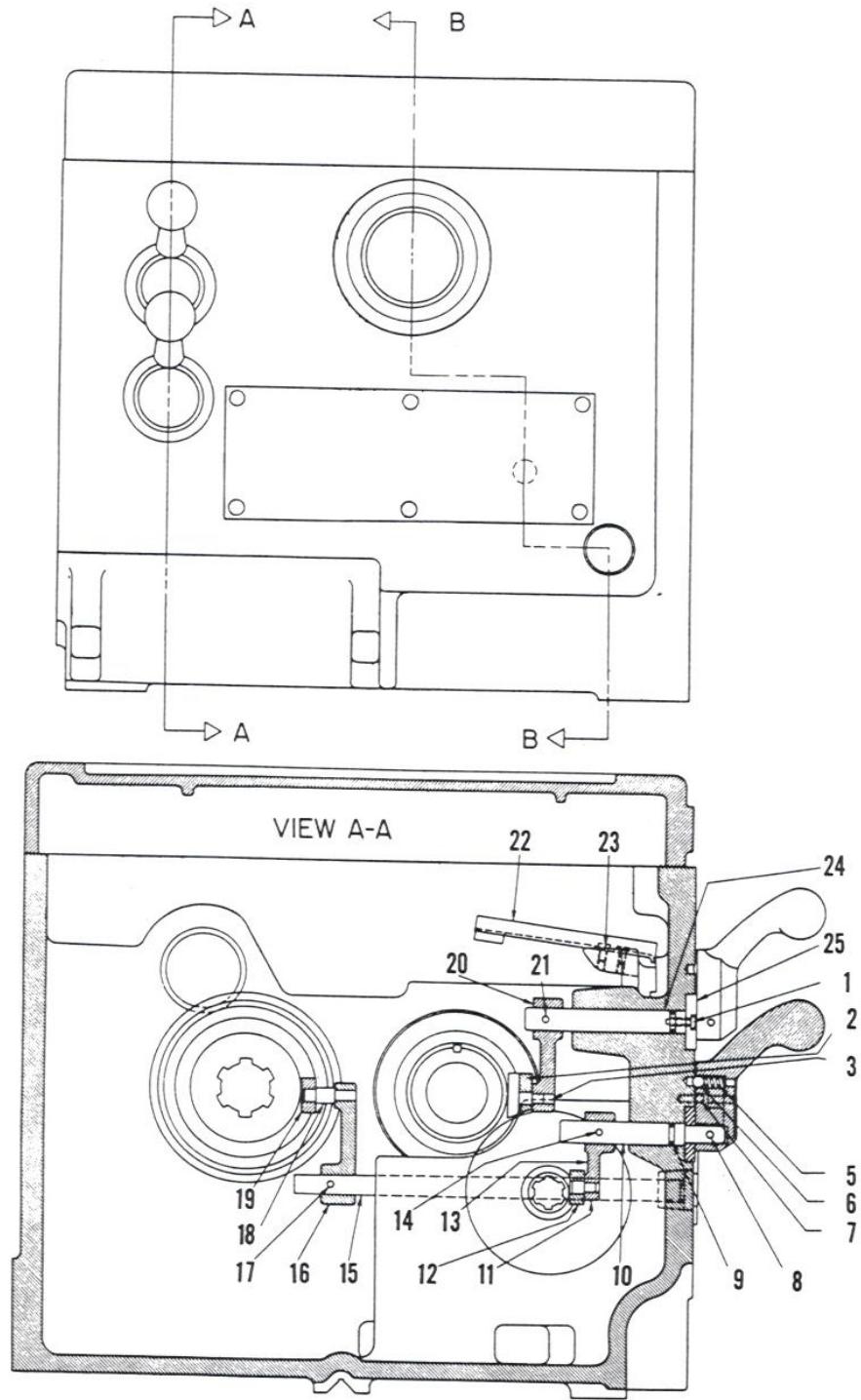


Figure 6

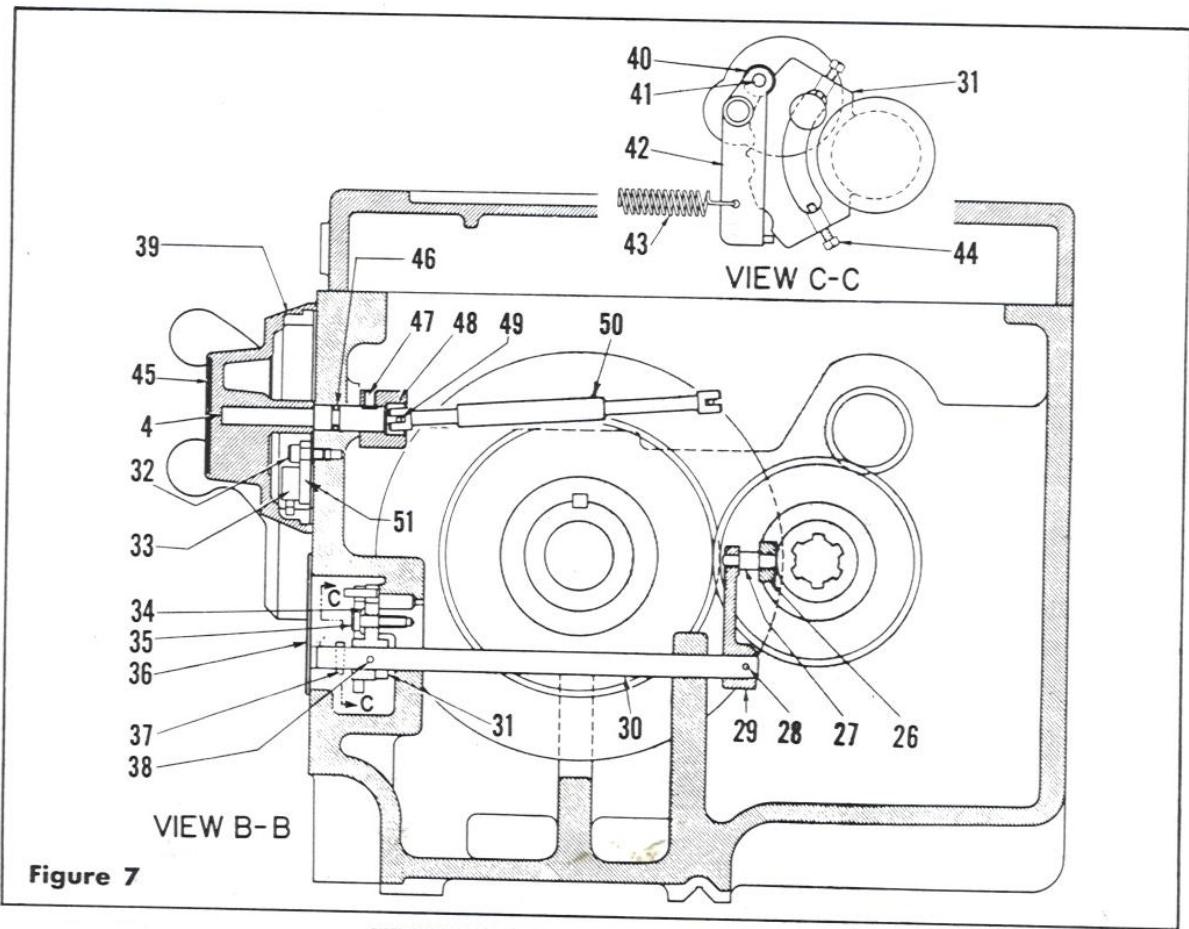
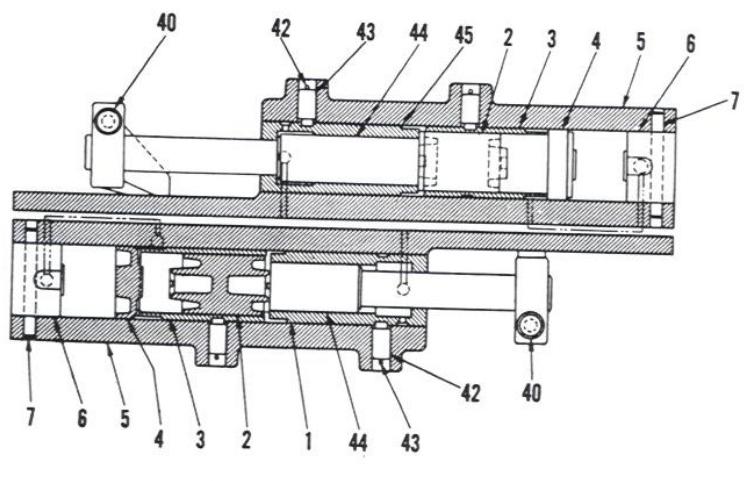


Figure 7

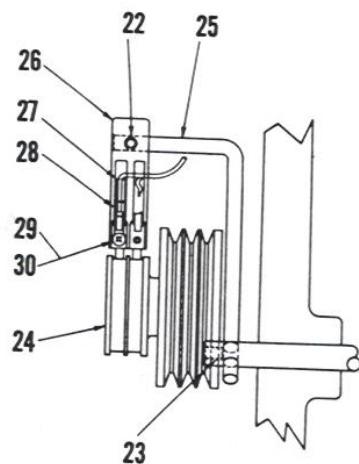
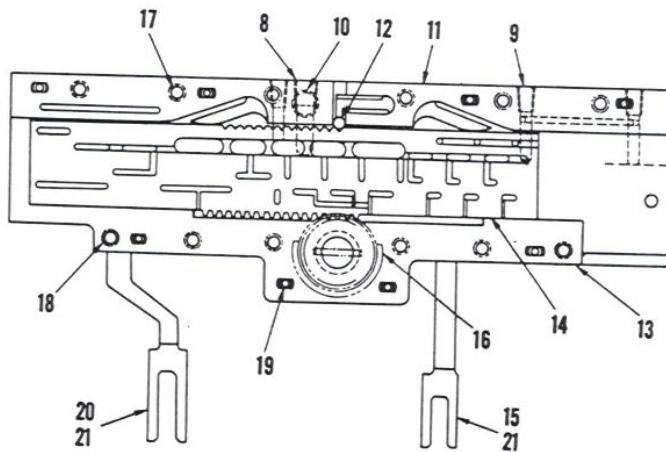
HEADSTOCK SHIFTER SECTIONS

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
6- 1	Screw, Phillips Head	4	7-27	Pin, Shifter	1
6- 2	Shoe, Shifter	1	7-28	Pin, Taper Draw	1
6- 3	Pin, Shoulder	1	7-29	Lever, Shifter	1
6- 4	Dial Shaft	2	7-30	Shaft, Inter. Shaft Slid. Back Gear Shift.	1
6- 5	Spring, Detent	2	7-31	Shifter, Ret. Yoke	2
6- 6	Ball	2	7-32	Screw	1
6- 7	Pin	4	7-33	Micro-Switch	1
6- 8	Pin, Taper	2	7-34	Washer, Nylon	2
6- 9	Ring, "O"	2	7-35	Screw	2
6-10	Shaft, Feed Comp. Shifter	1	7-36	Cover, Head Front	2
6-11	Pin, Shoulder	1	7-37	Pin, Taper	2
6-12	Shoe, Shifter Lever	1	7-38	Pin, Taper	2
6-13	Lever, Shifter	1	7-39	Speed Selector Dial (Specify Speed Range)	1
6-14	Pin, Taper	1	7-40	Roller, Det.	2
6-15	Shaft, Inter. Shaft Slid. Cluster Gear Shifter	1	7-41	Pin	2
6-16	Lever, Shifter	1	7-42	Arm	2
6-17	Pin, Taper Draw	1	7-43	Spring	1
6-18	Pin, Shifter	1	7-44	Screw	2
6-19	Shoe, Shifter Lever	1	7-45	Speed Dial	1
6-20	Lever, Shifter	1	7-46	'O' Ring	1
6-21	Pin, Taper	1	7-47	Set Screw	1
6-22	Scoop, Face Gear Oil	1	7-48	Coupling	1
6-23	Screw, Machine	2	7-49	Pin	1
6-24	Shaft, Fd. Rev. Gear Shifter	1	7-50	Coupling Shaft	1
6-25	Collar, Shifter Retainer	1	7-51	Bracket, Switch	1
7-26	Shoe, Shifter Lever	1			



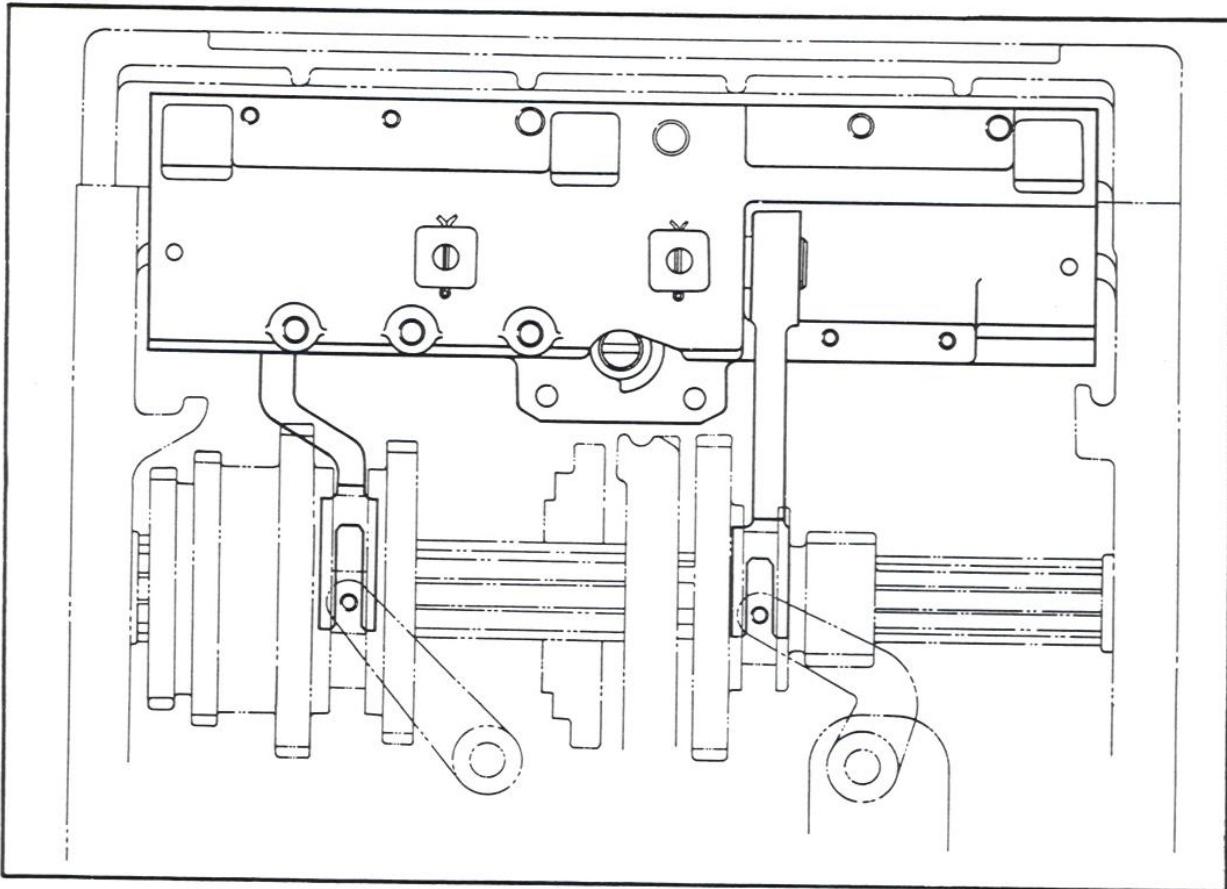
SERVO-SHIFT SHIFTER UNIT

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ZERO-SPEED SWITCH
(MAIN DRIVE MOTOR)

Figure 8

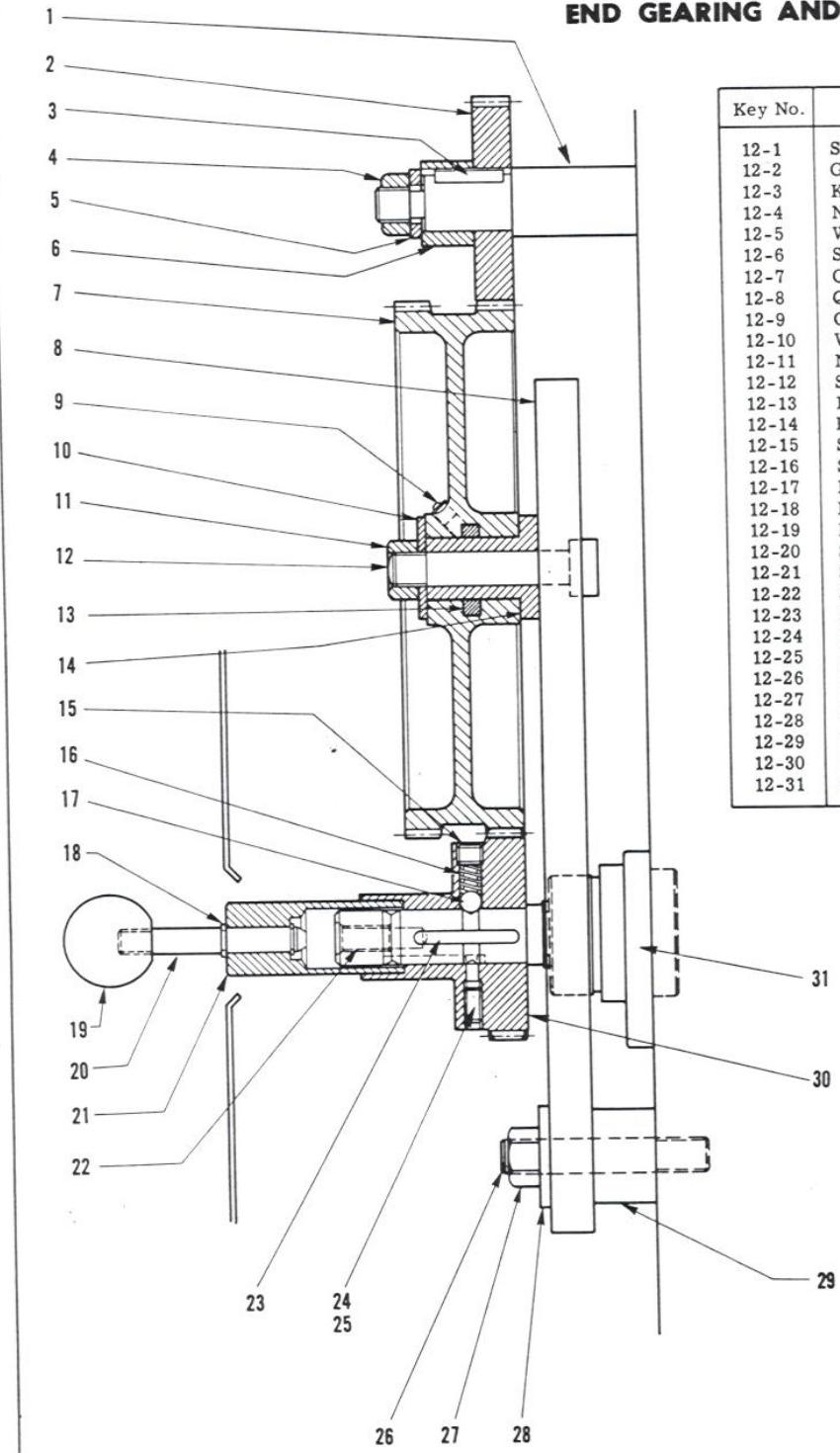


SERVO-SHIFT
ZERO-SPEED SWITCH, SHIFTER UNIT, DIAL ASSEMBLY

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
8- 1	Sleeve	1	8-24	Switch, Zero Speed	1
8- 2	Piston, Long	1	8-25	Arm, Brush Holder	1
8- 3	Liner	1	8-26	Brush Holder.	1
8- 4	Piston, Short.	1	8-27	Brush Spring.	2
8- 5	Cylinder	1	8-28	Brush	2
8- 6	Retainer	1	8-29	Binding Head Screw	2
8- 7	Pin, Oversize Dowel	1	8-30	Shake Proof Washer	2
8- 8	Plug, Pipe	1	8-31	Speed Selector Dial(Specify Speed Range)	1
8- 9	Plug, Pipe	3	8-32	Dial Shaft	1
8-10	Plug, Pipe	1	8-33	Set Screw	1
8-11	Spacer, Upper Cylinder	1	8-34	"O" Ring	1
8-12	Roller, Detent	1	8-35	Coupling	1
8-13	Spacer, Lower Cylinder	1	8-36	Pin	1
8-14	Slide, Valve	1	8-37	Coupling Shaft	1
8-15	Fork, "C" Cylinder	1	8-38	Speed Dial.	1
8-16	Pinion, Valve Slide (With Pin)	1	8-39	Screw	1
8-17	Screw, Socket Cap	6	8-40	Screw	2
8-18	Screw, Socket Cap	6	8-41	Micro-Switch.	1
8-19	Pin, Straight	2	8-42	Pin, Cotter	2
8-20	Fork, "B" Cylinder	1	8-43	Pin, Locating	2
8-21	Screw, Socket Cap	2	8-44	Piston, Rod	1
8-22	Set Screw	1	8-45	Bracket, Switch.	1
8-23	Set Screw	1			

IMPORTANT—Include serial number of your lathe when ordering repair parts.

END GEARING AND QUADRANT ASSEMBLY



Key No.	Part Name	Qty.
12-1	Shaft	1
12-2	Gear	1
12-3	Key	1
12-4	Nut	1
12-5	Washer	1
12-6	Spacer	1
12-7	Gear	1
12-8	Quadrant	1
12-9	Oiler	1
12-10	Washer	1
12-11	Nut	1
12-12	Stud	1
12-13	Felt	1
12-14	Bush	1
12-15	Screw, Set	1
12-16	Spring	1
12-17	Ball	1
12-18	Ring, Retaining	2
12-19	Handle	1
12-20	Shaft	1
12-21	Sleeve	1
12-22	Shaft	1
12-23	Key	1
12-24	Screw, Set	1
12-25	Pin	1
12-26	Stud	2
12-27	Nut	2
12-28	Washer	2
12-29	Spacer, Quadrant	2
12-30	Gear	1
12-31	Ring	1

Figure 12

QUICK CHANGE BOX

Feed Shaft - Feed Rod - Lead Screw Intermediate Shaft - Cone Shaft

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
10- 1	Screw - Set	1	10-36	15T., 21T. Gear	1	10-37	28T. Cone Gear.	1
10- 2	Collar .	1	10-37	26T. Cone Gear.	1	10-38	24T. Cone Gear.	1
10- 3	Pin, Taper .	1	10-39	24T. Cone Gear.	1	10-40	23T. Cone Gear.	1
10- 4	Bearing Race.	2	10-41	22T. Cone Gear.	1	10-42	Plug .	1
10- 5	Bearing .	1	10-42	Plug .	1	10-43	Tumbler Gear .	1
10- 6	"O" Ring .	1	10-43	Tumbler Gear .	1	10-44	Shaft, Tumbler Gear .	1
10- 7	Bushing, Lead Screw .	1	10-44	Pin .	1	10-45	Pin .	1
10- 8	Seal .	1	10-45	Plug, Flange .	1	10-46	Plug, Flange .	1
10- 9	Key .	1	10-47	Screw, Set .	1	10-47	Screw, Set .	1
10-10	Pinion, Lead Screw .	1	10-48	Screw, Set .	1	10-48	Screw, Set .	1
10-11	Lead Screw .	1	10-49	Screw, Set .	1	10-49	Sleeve .	1
10-12	Plug, Expansion .	1	10-50	Sleeve .	1	10-51	Gear .	1
10-13	Bushing, Clutch Gear .	1	10-51	Gear .	1	10-52	Ring, Retaining .	1
10-14	Gear, Clutch .	1	10-52	Ring, Retaining .	1	10-53	Screw .	1
10-15	Ring, Retaining .	1	10-53	Screw .	1	10-54	Spring .	1
10-16	Gear .	1	10-54	Spring .	1	10-55	Ball .	1
10-17	Ring, Retaining .	1	10-55	Ball .	1	10-56	Bushing, Box .	1
10-18	Feed Shaft .	1	10-56	Bushing, Box .	1	10-57	Pin .	1
10-19	Ring, Retaining .	1	10-57	Pin .	1	10-58	Bearing, Plain .	1
10-20	Plug, Expansion .	1	10-58	Bearing, Plain .	1	10-59	Gasket .	1
10-21	Key, Cone Gear .	1	10-59	Gasket .	1	10-60	Drive Gear .	1
10-22	20T. Cone Gear .	1	10-60	Drive Gear .	1	10-61	Yoke .	1
10-23	18T. Cone Gear .	1	10-61	Yoke .	1	10-62	Pin, Taper .	1
10-24	16T. Cone Gear .	1	10-62	Pin, Taper .	1	10-63	Bushing .	1
10-25	Seal .	1	10-63	Bushing .	1	10-64	Handle .	1
10-26	Pin, Taper .	1	10-64	Handle .	1	10-65	Shaft .	1
10-27	Gear, Safety Clutch .	1	10-65	Shaft .	1	10-66	Ring, Retaining .	1
10-28	Plug .	1	10-66	Ring, Retaining .	2	10-67	Pin .	1
10-29	Ball .	2	10-67	Pin .	1	10-68	Screw .	1
10-30	Spring .	1	10-68	Screw .	1	10-69	Key .	1
10-31	Pin, Taper .	1	10-69	Key .	1			
10-32	Collar, Safety Clutch .	1						
10-33	Feed Rod .	1						
10-34	Cone Shaft .	1						
10-35	15T. Gear .	1						

IMPORTANT—Include serial number of your lathe when ordering repair parts.

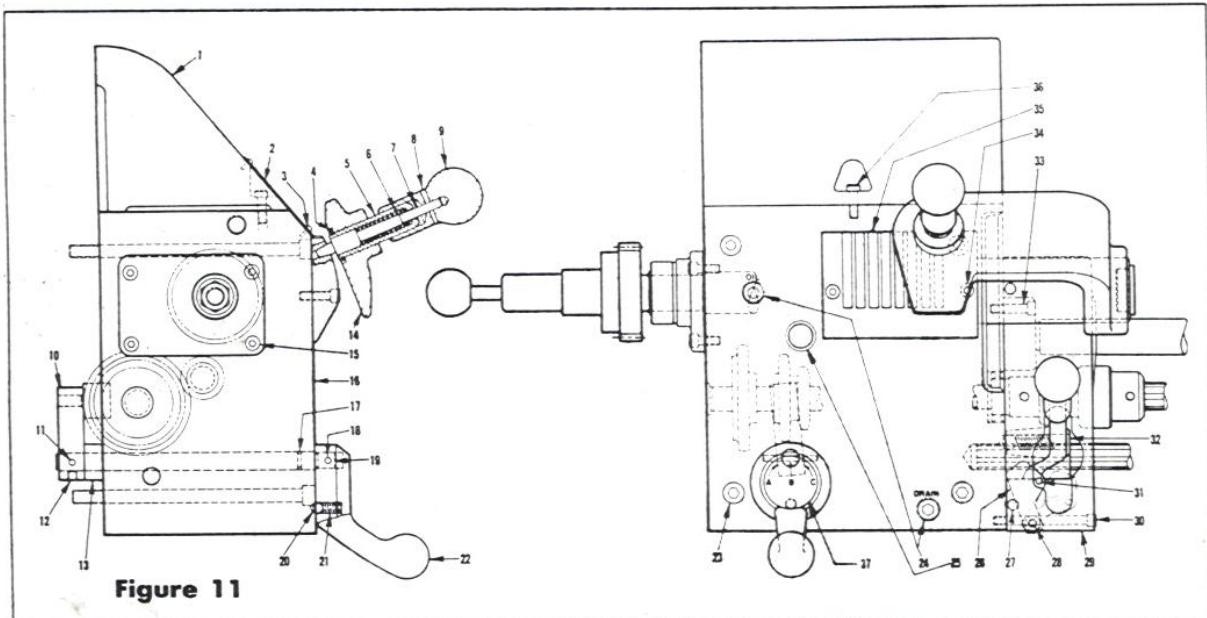


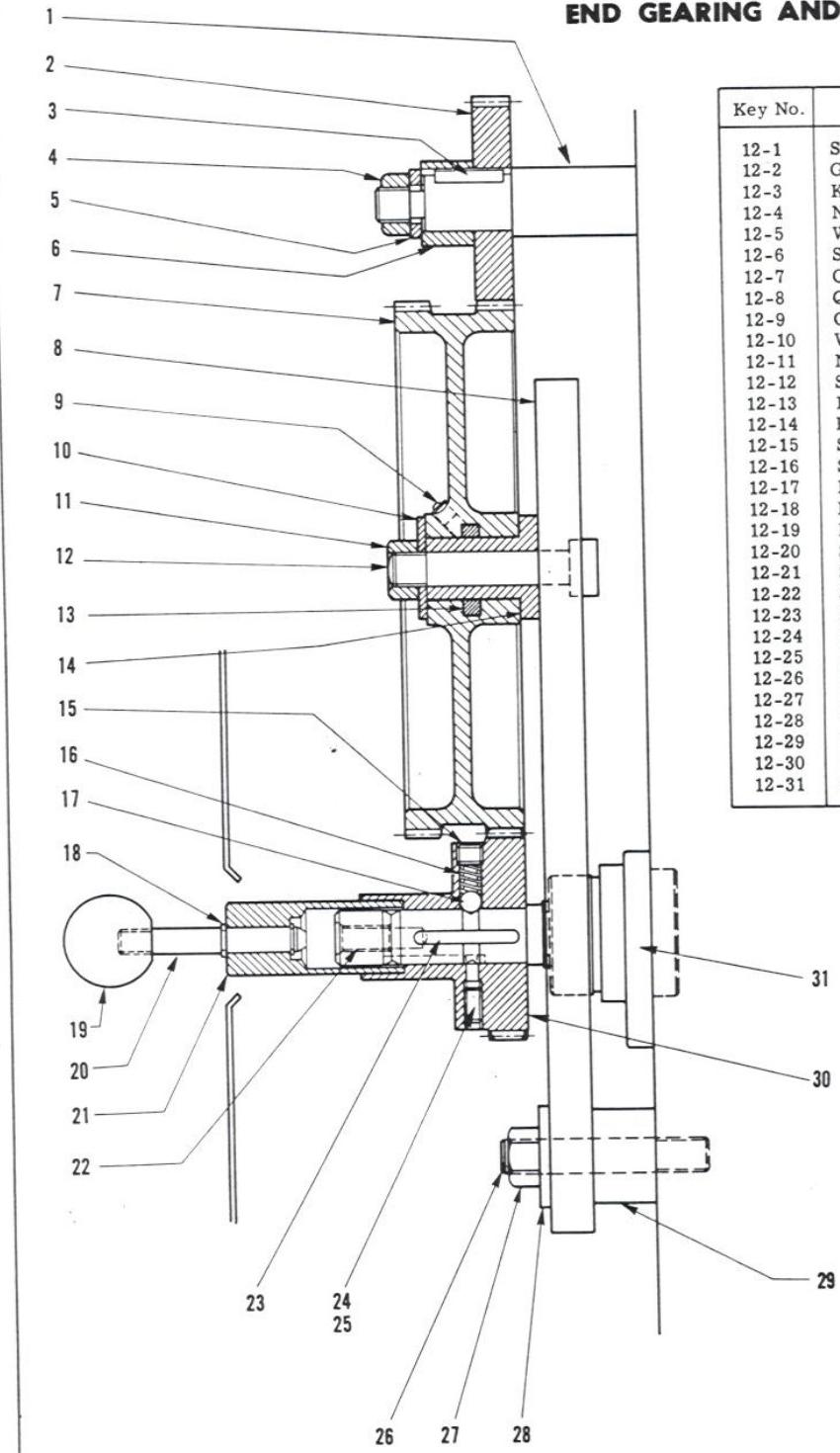
Figure 11

QUICK CHANGE BOX CASTING

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
11- 1	Cover, Quick Change Box Top	1	11-20	Ball	1
11- 2	Index Plate	1	11-21	Spring	1
11- 3	Pin	4	11-22	Handle, Shifter	1
11- 4	Ring, Retaining	1	11-23	Screw	4
11- 5	Sleeve	1	11-24	Pipe Plug	2
11- 6	Spring	1	11-25	Window, Oil Sight	1
11- 7	Plunger, Index	1	11-26	Latch, Safety.	1
11- 8	Pin, Taper	1	11-27	Pin	2
11- 9	Handle, Shifter	1	11-28	Screw	1
11-10	Arm, Shifter	1	11-29	Cover, Slip Gear	1
11-11	Pin, Taper	1	11-30	Screw	2
11-12	Screw, Set	1	11-31	Pin	1
11-13	Spacer	1	11-32	Handle, Spindle Control	1
11-14	Arm, Shifter	1	11-33	Screw	2
11-15	Screw	4	11-34	Screw	2
11-16	Quick Change Box	1	11-35	Block, Tumbler Lock	1
11-17	"O" Ring	1	11-36	Screw	1
11-18	Pin, Taper	1	11-37	Plate, Feed Comp.	1
11-19	Shaft, Shifter.	1			

IMPORTANT—Include serial number of your lathe when ordering repair parts.

END GEARING AND QUADRANT ASSEMBLY



Key No.	Part Name	Qty.
12-1	Shaft	1
12-2	Gear	1
12-3	Key	1
12-4	Nut	1
12-5	Washer	1
12-6	Spacer	1
12-7	Gear	1
12-8	Quadrant	1
12-9	Oiler	1
12-10	Washer	1
12-11	Nut	1
12-12	Stud	1
12-13	Felt	1
12-14	Bush	1
12-15	Screw, Set	1
12-16	Spring	1
12-17	Ball	1
12-18	Ring, Retaining	2
12-19	Handle	1
12-20	Shaft	1
12-21	Sleeve	1
12-22	Shaft	1
12-23	Key	1
12-24	Screw, Set	1
12-25	Pin	1
12-26	Stud	2
12-27	Nut	2
12-28	Washer	2
12-29	Spacer, Quadrant	2
12-30	Gear	1
12-31	Ring	1

Figure 12

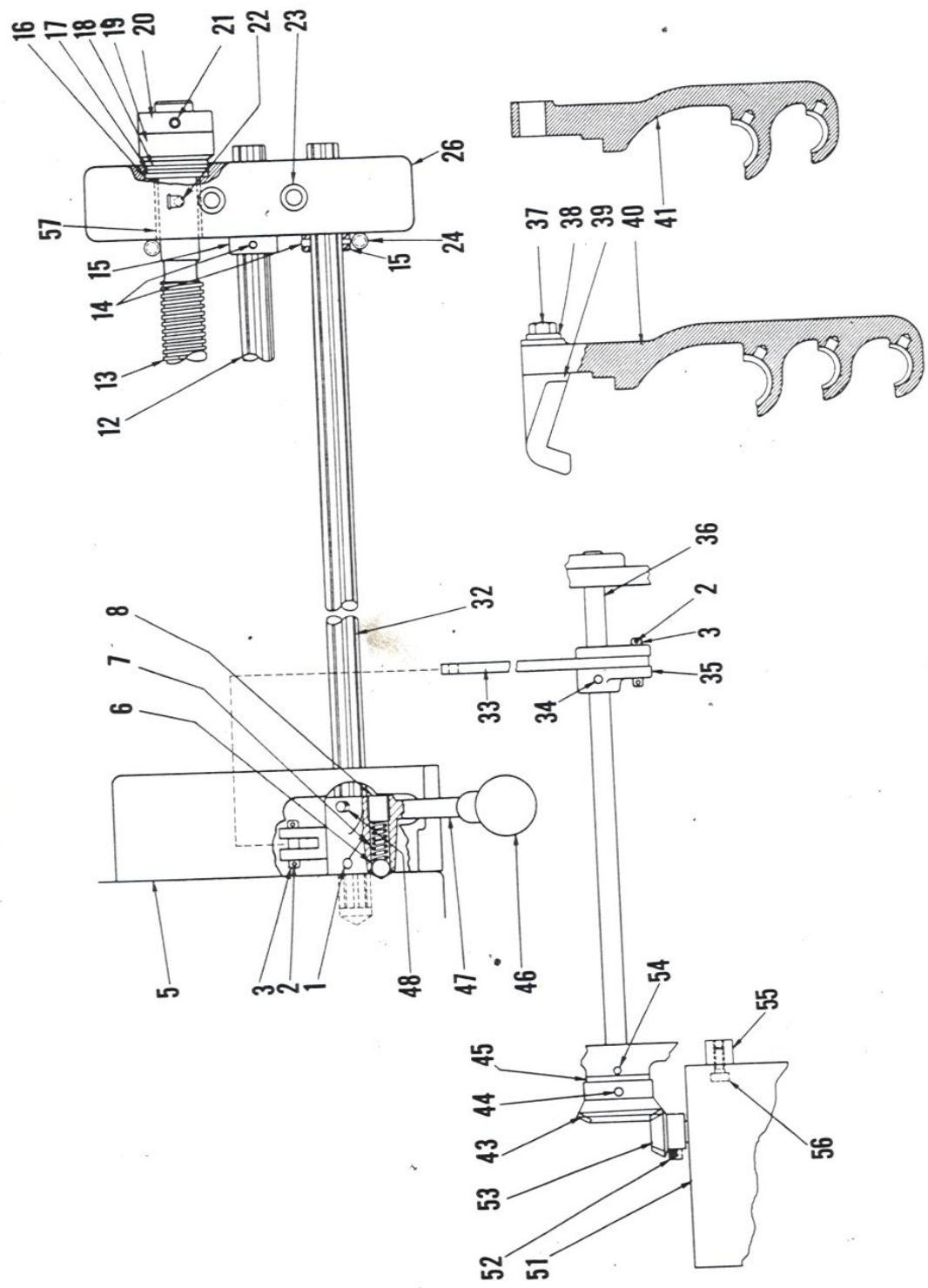


Figure 13

SPINDLE CONTROL

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
13- 1	Screw, Set	1	13-32	Control Rod	1
13- 2	Cotter Pin	4	13-33	Link	1
13- 3	Pin	2	13-34	Taper Pin	1
13- 5	Cover, Slip Gear	1	13-35	Shifter	1
13- 6	Ball	1	13-36	Control Rod	1
13- 7	Spring	1	13-37	Screw	1
13- 8	Set Screw	1	13-38	Washer	1
13-12	Feed Rod	1	13-39	Block	1
13-13	Lead Screw	1	13-40	Support	1
13-14	Taper Pin	2	13-41	Support	1
13-15	Collar	2	13-43	Bevel Gear	1
13-16	Bearing Race	1	13-44	Taper Pin	1
13-17	Bearing	1	13-45	Washer	1
13-18	Bearing Race	1	13-47	Spindle Control Handle	1
13-19	Collar	1	13-48	Draw Pin	1
13-20	Nut	1	13-51	Switch	1
13-21	Set Screw	1	13-52	Set Screw	1
13-22	Oil Cup	1	13-53	Bevel Gear	1
13-23	Screw	2	13-54	Pin (19 Only)	1
13-24	Draw Pin	2	13-55	Spacer	1
13-26	F.....Box	1	13-56	Screw	1
13-30	Snap Ring	1	13-57	Bushing	1
13-31	Sleeve	4			

IMPORTANT — Include serial number of your lathe when ordering repair parts

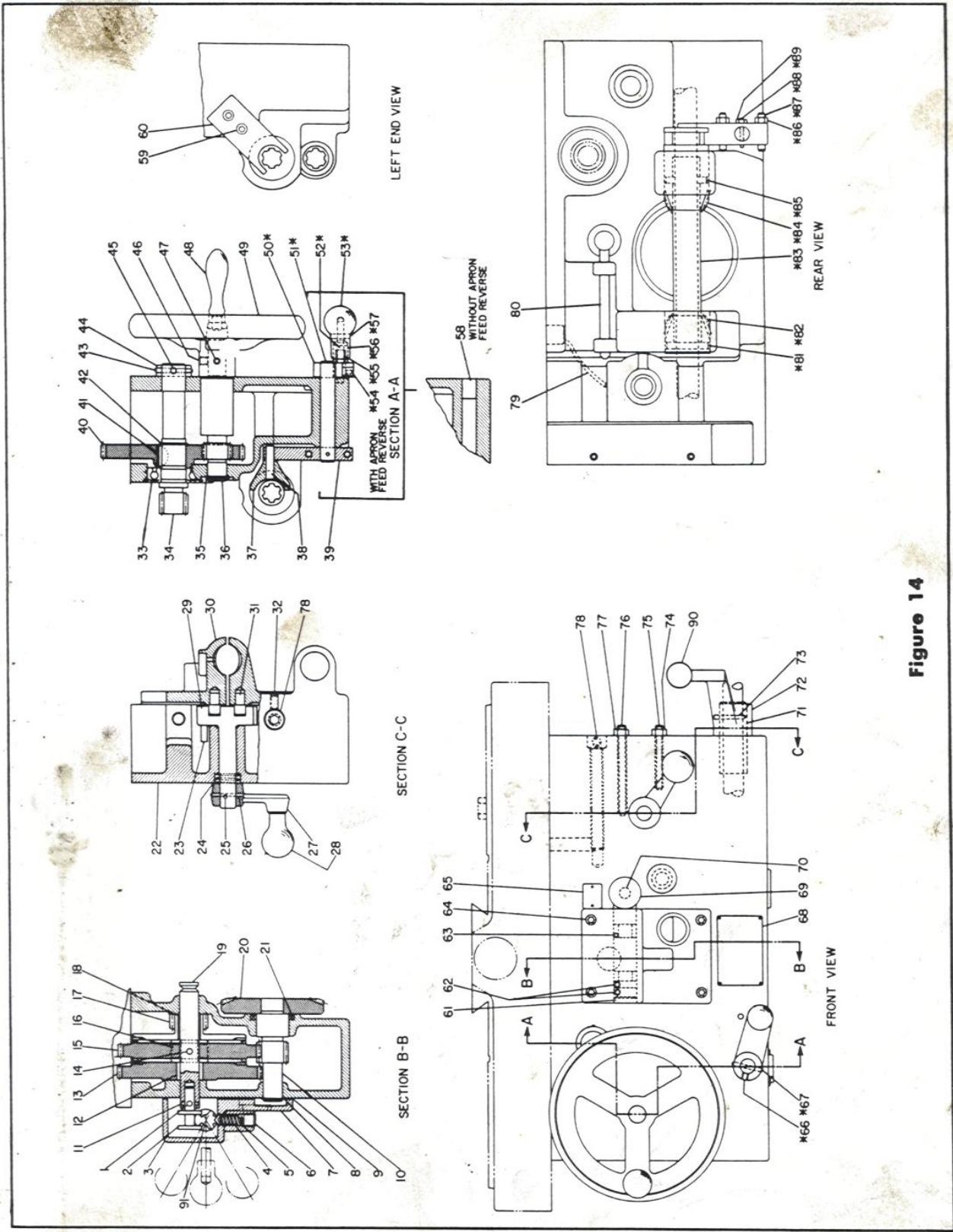


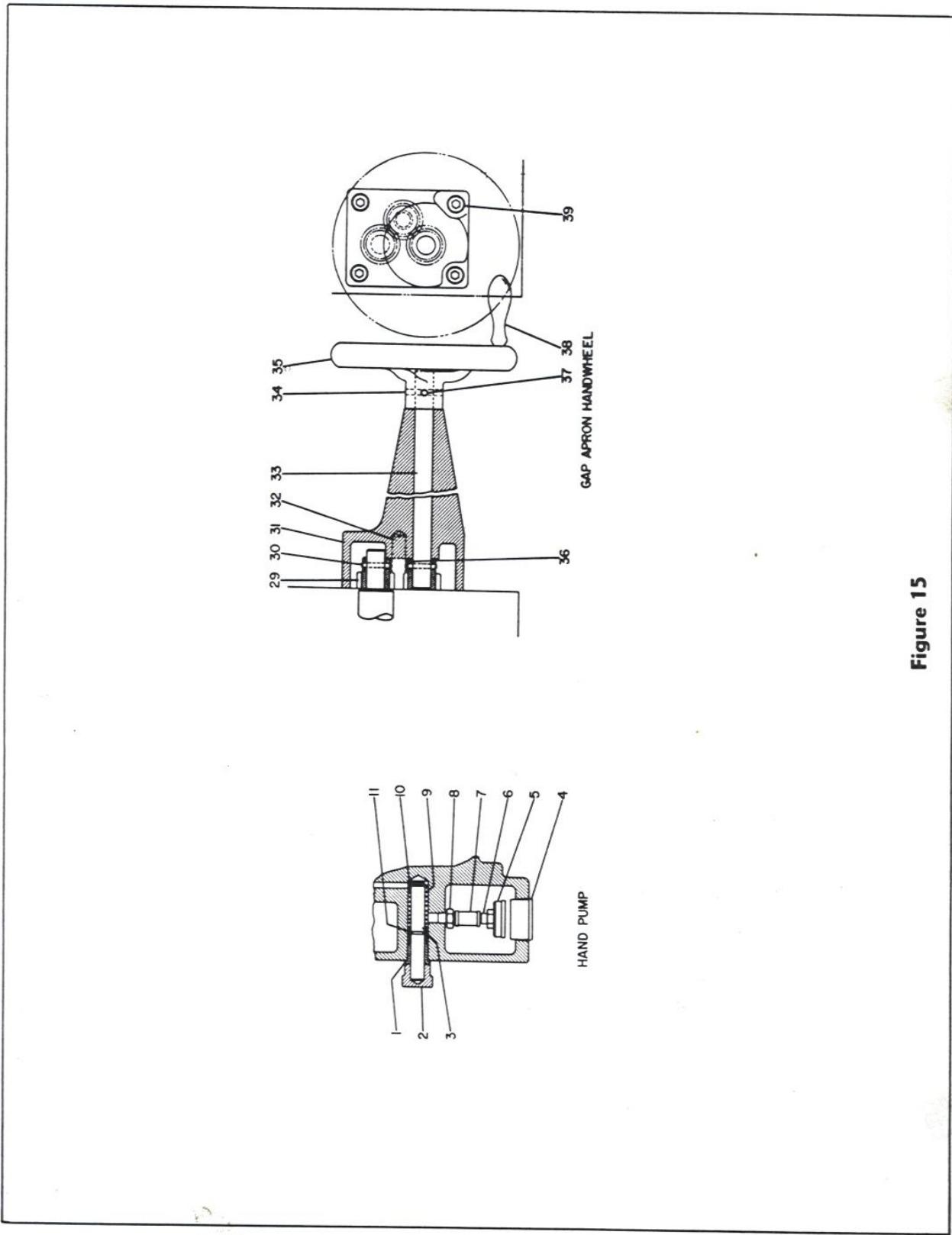
Figure 14

APRON ASSEMBLY

Key No.	Part Name	Qty.	Key. No.	Part Name	Qty.	Key No.	Part Name	Qty.
14- 1	Screw	1	14-31	Pin	2	14-61	Plug	1
14- 2	Stud	1	14-32	Bearing - Ball	2	14-62	Screw	4
14- 3	Housing	1	14-33	Pinion - Rack	1	14-63	Pin	1
14- 4	Plunger	1	14-34	Ring - Truarc	1	14-64	Screw	2
14- 5	Spring	1	14-35	Stud - First	1	14-65	Plate	1
14- 6	Plug	1	14-36	Shoe	1	*14-66	Screw	1
14- 7	Window	1	14-37	Pin	1	*14-67	Pin - Taper	1
14- 8	Ring - Truarc	1	14-38	Pin	1	14-68	Plate	1
14- 9	Gasket	1	14-39	Lever	1	14-69	Knob	1
14-10	Shaft	1	14-40	Gear	1	14-70	Rod	1
14-11	Pin, Taper	1	14-41	Key	1	14-71	Sleeve	1
14-12	Bushing	1	14-42	Ring - Truarc	1	14-72	Handle	1
14-13	Gear	1	14-43	Pin - Taper	1	14-73	Pin - Taper	1
14-14	Pin	1	14-44	Collar	1	14-74	Nut	1
14-15	Gear	1	14-45	Screw	1	14-75	Screw	1
14-16	Pin	4	14-46	Screw	1	14-76	Screw	1
14-17	Gear	1	14-47	Pin - Taper	1	14-77	Nut	1
14-18	Bushing	1	14-48	Handle	1	14-78	Screw	2
14-19	Shaft	1	14-49	Handwheel	1	14-79	Tubing - Copper	1
14-20	Gear	1	*14-50	Handle	1	14-80	Pin - Interference	1
14-21	Seal	1	*14-51	Shaft	1	*14-81	Pin	2
14-22	Apron	1	*14-52	Plunger	1	*14-82	Pinion	1
14-23	Pin	1	*14-53	Knob	1	*14-83	Sleeve	1
14-24	Spring	1	*14-54	Pin	1	*14-84	Pinion - Shifter	1
14-25	Screw	1	*14-55	Spring	1	*14-85	Pin	2
14-26	Pin	1	*14-56	Sleeve	1	*14-86	Nut	2
14-27	Handle	1	*14-57	Pin - Taper	1	*14-87	Screw	2
14-28	Knob	1	14-58	Plug - Without Feed Reverse	1	*14-88	Pin - Draw	1
14-29	Cam.	1	14-59	Screw	2	*14-89	Nut	1
14-30	Half Nut	1	14-60	Block - Trip	1	14-90	Knob	1
						14-91	Shaft	1

*Used With Apron Feed Reverse Only

Figure 15



APRON ASSEMBLY

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
15- 1	Bushing .	1	15-29	Pinion .	.
15- 2	Knob .	1	15-30	Pin - Taper .	.
15- 3	Piston .	1	15-31	Housing .	.
15- 4	Plug .	1	15-32	Pin .	.
15- 5	Filter. .	1	15-33	Shaft .	.
15- 6	Nipple .	1	15-34	Pin - Taper .	.
15- 7	Coupling. .	1	15-35	Handwheel .	.
15- 8	Valve - Check .	1	15-36	Bearing - Bronze .	.
15- 9	Spring .	1	15-37	Screw .	.
15-10	Ring - Truarc .	1	15-38	Handle .	.
15-11	Cup Huva .	1	15-39	Screw .	4

IMPORTANT — Include serial number of your lathe when ordering repair parts

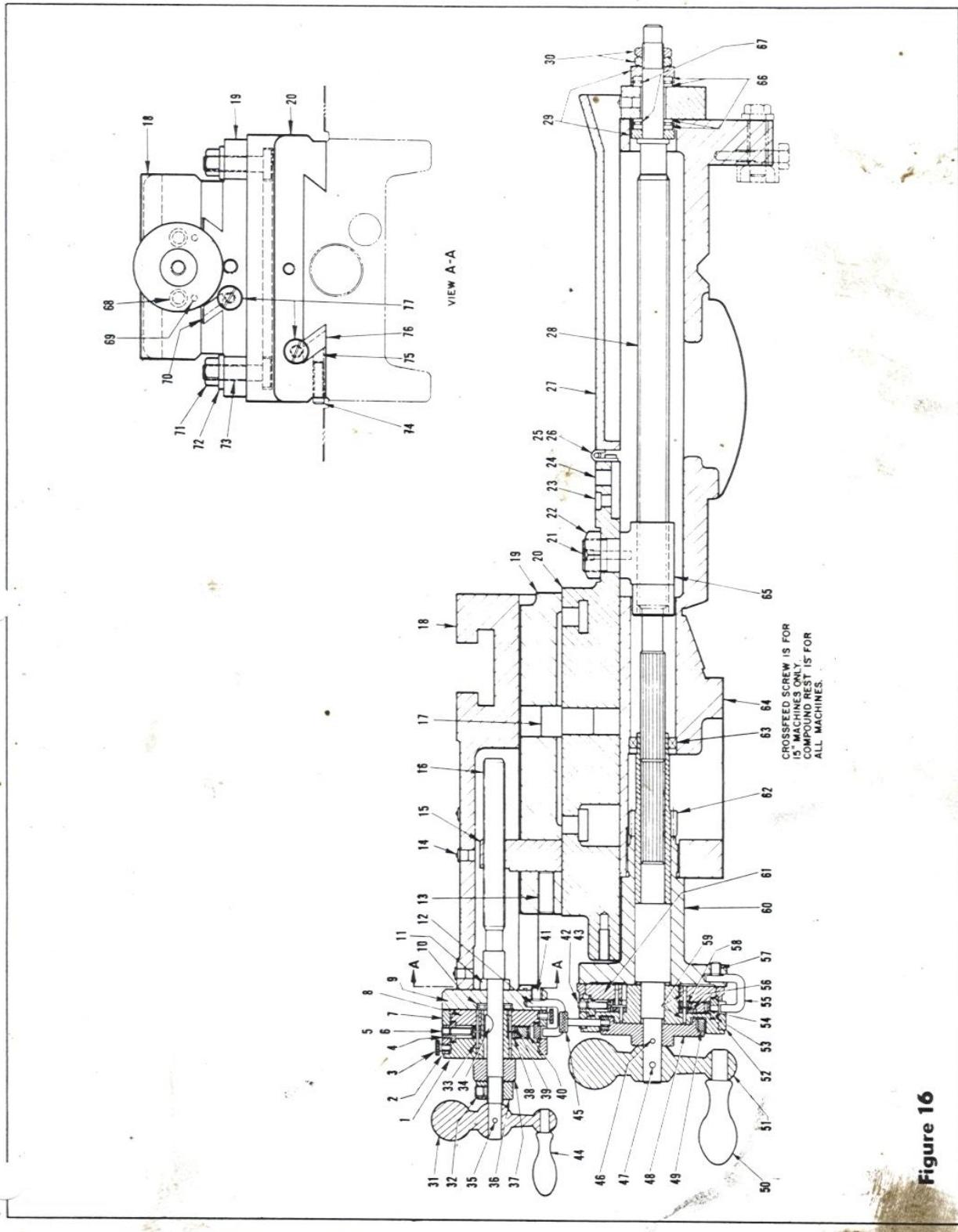


Figure 16

COMPOUND REST

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.	Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
16- 1	Sleeve	1	16-44	Handle	1	16-45	Screw	1	16-45	Screw	1
16- 2	Dial (English) Black Numbers	1	16-46	Pin, Taper	2	16-46	Pin, Taper	1	16-47	Pin, Taper	1
16- 3	Screw	1	16-47	Sleeve	1	16-48	Ring	1	16-48	Ring	1
16- 4	Ring	1	16-49	Handle	1	16-50	Handle	1	16-51	Handle	1
16- 5	Screw, Set	1	16-52	Dial (English) Black Letters	1	16-53	Ring	2	16-54	Gear, Ring	1
16- 6	Screw, Set	1	16-55	Rod, "U"	1	16-55	Gear, (12T)	1	16-56	Gear, (12T)	1
16- 7	Dial (Metric) Red Numbers	1	16-57	Screw, Set	4	16-57	Gear, (120T)	1	16-58	Gear, (120T)	4
16- 8	Hub	1	16-59	Pin, Roll	1	16-60	Bush	1	16-61	Dial (Metric) Red Letters	1
16- 9	Bush	1	16-62	Sleeve, Pinion	1	16-63	Clipper Seal	1	16-64	Carriage	1
16-10	Bearing	1	16-64	Nut, Crosshead Screw (English)	1	16-65	(Metric)	1	16-66	Bearing	1
16-11	Collar	1	16-66	Bearing	1	16-67	Bearing	1	16-67	Screw, Top Slide Bushing	2
16-12	Rod, "U"	1	16-68	Pin, Spiral	1	16-69	Pin, Spiral	1	16-70	Gib, Top Slide	4
16-13	Screw, Set	1	16-71	Nut, Hex	1	16-71	Nut, Hex	2	16-72	Washer	2
16-14	Oiler	1	16-72	Bolt, T-slot	1	16-73	Bolt, T-slot	2	16-74	Screw, Set	1
16-15	Nut, Top Slide (English). (Metric)	1	16-74	Plug	2	16-75	Plug	1	16-75	Gib, Bottom Slide	1
16-16	Screw, Top Slide (English) (Metric)	1	16-75	Gib	1	16-76	Gib	1	16-76	Screw, Gib	4
16-17	Pin, Shoulder	1	16-77	Screw, Gib	1						
16-18	Slide, Top	1									
16-19	Slide, Swivel.	1									
16-20	Slide, Bottom	1									
16-21	Screw, Set	1									
16-22	Nut, Special Hex	1									
16-23	Plug (Not used when Taper Attachment is furnished).	1									
16-24	Plug (Not used when Taper Attachment is furnished).	1									
16-25	Hinge, Dirt Guard	1									
16-26	Screw, Special Socket Head	1									
16-27	Guard, Dirt	1									
16-28	Screw, Crosshead (English) (Metric)	1									
16-29	Sleeve	1									
16-30	Nut	1									
16-31	Handle	1									
16-32	Screw, Set	1									
16-33	Pin, Roll	1									
16-34	Key	1									
16-35	Pin, Taper	1									
16-36	Nut, Lock	1									
16-37	Spacer	1									
16-38	Gear, (64T)	1									
16-39	Gear, (63T)	1									
16-40	Gear, Ring	1									
16-41	Screw, Set	1									
16-42	Screw, Set	1									
16-43	Screw, Set	1									

+Gibs are furnished slightly oversize. Customer to fit and cut to suit on assembly.

*These parts are for 15" machines only. See Figure 14 for 19".

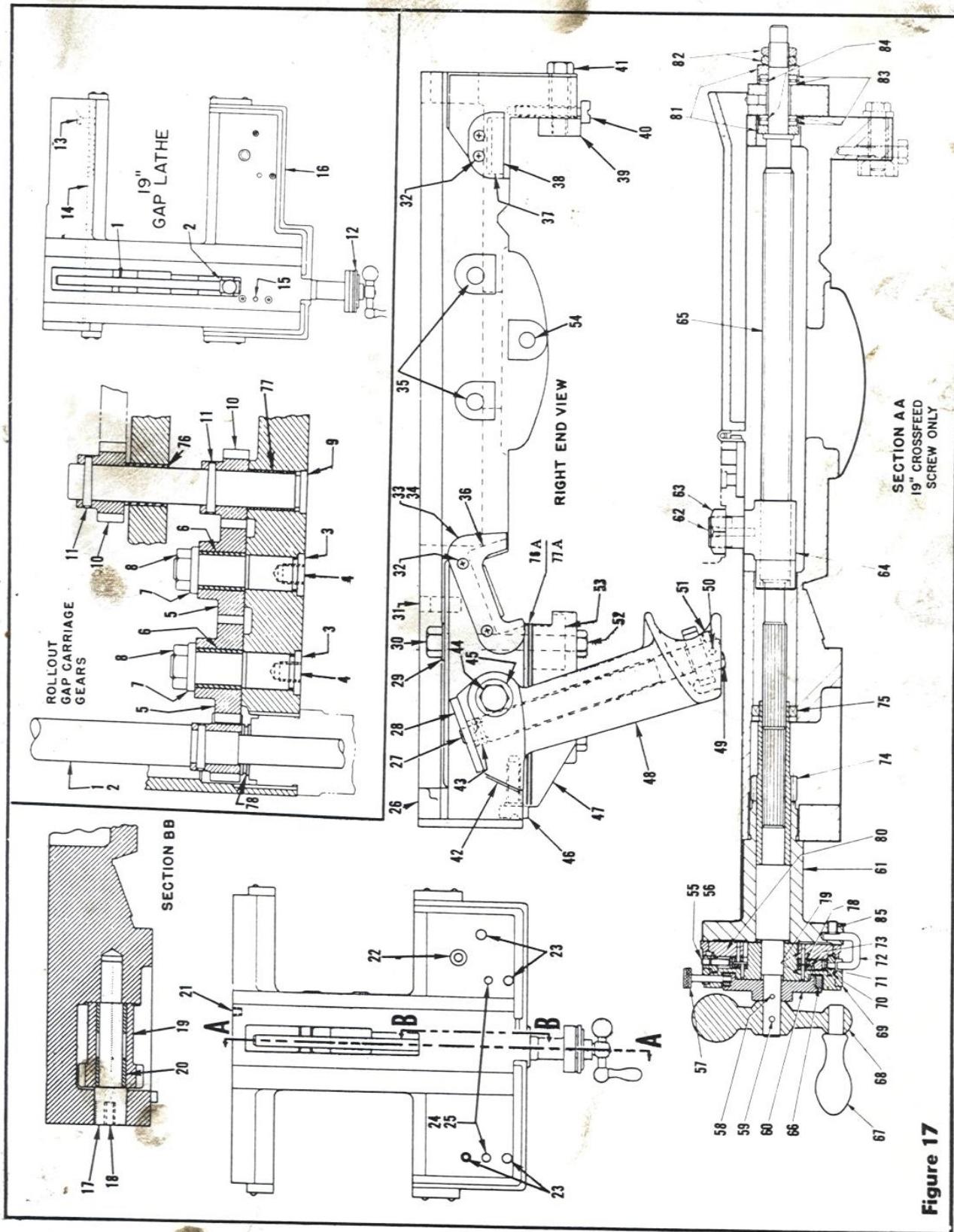


Figure 17

19" PLAIN AND SLIDING BED GAP LATHES
ROLL-OUT OF GAP LATHE CARRIAGE & CROSS FEED SCREW

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.	Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
17- 1	Screw, Cross Feed (Without Taper Attachment - English)	1	17- 3	Stud, Cross Feed Intermediate	2	17-12	Collar, Graduated (With or Without Taper Attachment - English)	1			
	(Without Taper Attachment - Metric)		17- 4	Gear, Cross Feed Plug, Pipe	2						
	(With Taper Attachment - Metric)		17- 5	Gear, Cross Feed Intermediate	2	17-13	Screw, Hex Cap (With or Without Taper Attachment - Metric)	1			
	(With Taper Attachment - English)		17- 6	Bush, Cross Feed	2	17-14	Gib, Rear	2			
	(With Taper Attachment - English)		17- 7	Intermediate Gear	2	17-15	Pin, Taper	1			
	(With Taper Attachment - Metric)		17- 8	Washer	2	17-16	Carriage	1			
	Nut, Cross Feed	1	17- 9	Nut, Hex	2	17-17	Bushing, Shaft Cross Feed	1			
	(With or Without Taper Attachment - English)		17-10	Shaft, Cross Feed Driving	1	17-76	Bushing, Shaft Cross Feed	1			
	(With or Without Taper Attachment - English)		17-11	Gear, Cross Feed Driving	2	17-77	Bearing, Cross Feed	1			
	(With or Without Taper Attachment - Metric)		17-12	Pin, Taper	2	17-78	Bearing, Cross Feed	2			

CARRIAGE AND CHASING DIAL

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.	Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
17-17	Stud, Idler Pinion	1	17-40	Screw, Gib	2	17-63	Nut, Special Hex	1			
17-18	Screw, Set	1	17-41	Screw, Hex Cap	2	17-64	Nut, Cross Feed Screw (English)	1			
17-19	Pinion, Idler	1	17-42	Plate, Chasing Dial Instruction	1	17-65	Nut, Cross Feed Screw (Metric)	1			
17-20	Bush, Oiler	2	17-43	Pin, Taper	1						
17-21	Pipe, Plug	1	17-44	Screw, Cap	1						
17-22	Screw	1	17-45	Washer	1	17-66	Ring	1			
17-23	Screw	4	17-46	Screw, Gib	2	17-67	Handle	1			
17-24	Pin	2	*17-47	Gib, Carriage Front	2	17-68	Handle	1			
17-25	Plug	1	17-48	Bracket, Dial	1	17-69	Dial (English) Black Letters	1			
17-26	Carriage	1	17-49	Wheel, Chasing Dial Worm	1	17-70	Ring	1			
17-27	Shaft Bracket	1	17-50	Pin, Taper	1	17-71	Gear, Ring	1			
17-28	Dial	1	17-51	Screw, Set	1	17-72	Rod "U"	1			
17-29	Washer	1	17-52	Screw, Hex Cap	4	17-73	Gear (127 T)	1			
17-30	Screw, Hex Cap	1	17-53	Clamp, Carriage	1	17-74	Sleeve, Pinion	1			
17-31	Plug	1	17-54	Screw	1	17-75	Clipper Seal	1			
17-32	Screw, Round Head Mach.	8	The following parts are for 19" Cross Feed Screw Only			17-76A	Shim -.002				A.R.
17-33	Wiper, Shear Front Right Hand	1				17-77A	Shim -.005				A.R.
17-34	Wiper, Shear Front Left Hand	1	17-55	Screw, Set	1	17-78	Gear (120T)	1			
17-35	Screw	2	17-56	Screw, Set	1	17-79	Pin, Roll	4			
*17-36	Neoprene	2	17-57	Screw	1	17-80	Dial	1			
*17-37	Neoprene	2	17-58	Pin, Taper	1	17-81	Sleeve	2			
17-38	Wiper, Shear Rear	2	17-59	Pin, Taper	1	17-82	Nut	2			
*17-39	Gib, Carriage Rear	2	17-60	Sleeve	1	17-83	Bearing	4			
			17-61	Bush	1	17-84	Bearing	2			
			17-62	Screw, Set	1	17-85	Screw, Set	1			

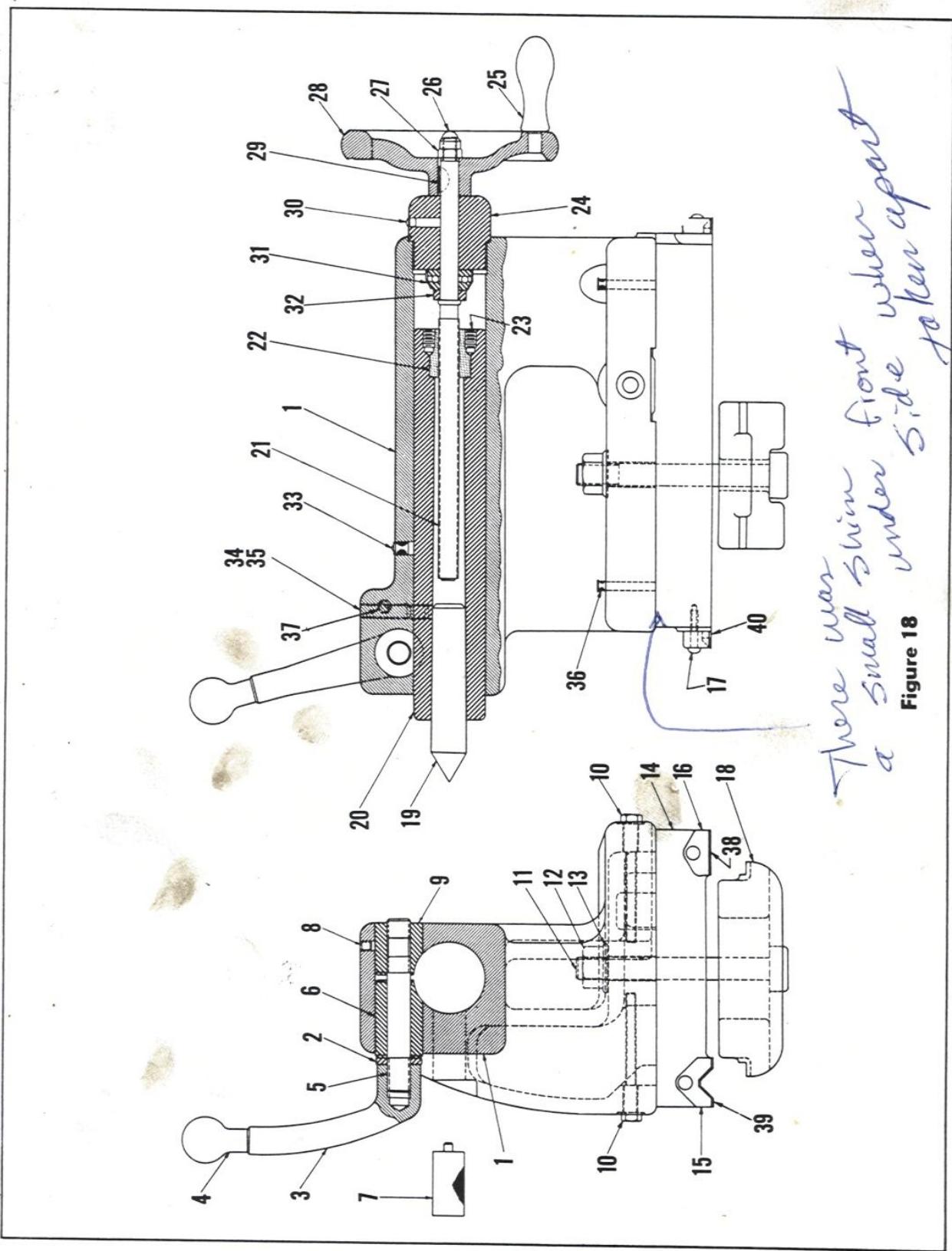


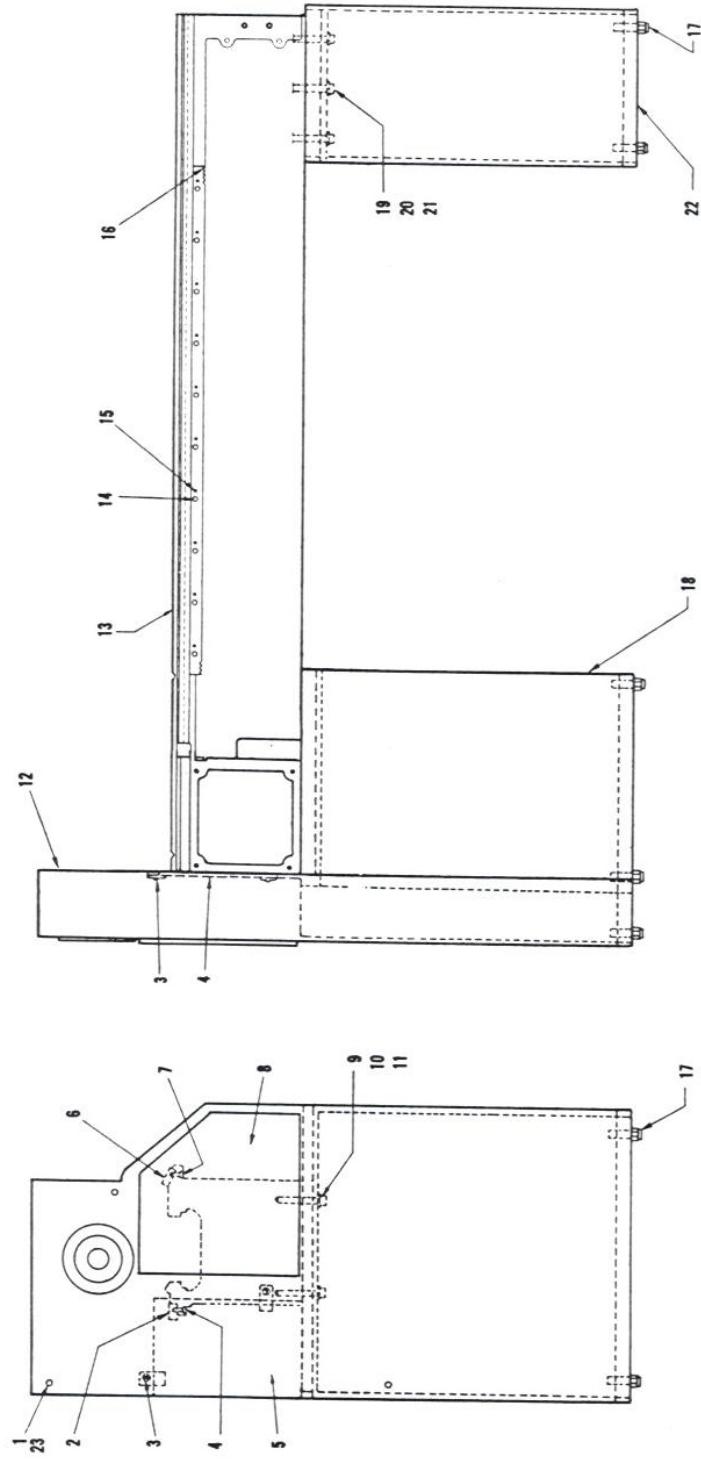
Figure 18

TAILSTOCK

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
18- 1	Top, Tailstock	1	18-21	Screw, Spindle	1
18- 2	Washer	1	18-22	Nut, Tailstock	1
18- 3	Handle, Binder	1	18-23	Screw, Set	2
18- 4	Handle, Ball	1	18-24	Cap, Tailstock	1
18- 5	Stud, Tailstock	1	18-25	Handle, Ball	1
18- 6	Bush, Upper Binder	1	18-26	Nut, Acorn	1
18- 7	Key, Plug	1	18-27	Nut, Hex	1
18- 8	Pin Stop	1	18-28	Handwheel	1
18- 9	Bush, Lower Binder	1	18-29	Key, Woodruff	1
18-10	Screw, Hex Cap	1	18-30	Oiler	1
18-11	Bolt, Rough	1	18-31	Bearing, Ball	1
18-12	Nut, Hex	1	18-32	Collar, Spindle Screw	1
18-13	Washer	1	18-33	Oiler	1
18-14	Bottom, Tailstock	1	18-34	Screw, Set	2
18-15	Wiper, Rear Shear	2	18-35	Plug, Brass	2
18-16	Wiper, Front Shear	2	18-36	Oiler	2
18-17	Screw	4	18-37	Pin Stop	1
18-18	Clamp, Tailstock	1	*18-38	Front Neoprene	1
18-19	Center, Spindle	1	*18-39	Rear Neoprene	1
18-20	Spindle, Tailstock	1	18-40	Felt	2

*Neoprene is furnished slightly oversize. Customer to fit and cut to suit on assembly.

Figure 19



BED, LEGS & HEAD END COVER

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
19- 1	Screw, Socket Head Cap	3	19-13	Bed (Specify Length)	
19- 2	Shear, Rear (Specify Center Capacity)	1	19-14	Screw	
19- 3	Screw, Hex Head Cap	3	19-15	Pin, Taper	
19- 4	Screw	Var. No.	19-16	Rack (Specify Center Capacity)	
19- 5	Plate, Head Feed Cover Back	1	19-17	Screw, Leveling (Head and Tail Legs)	
19- 6	Shear, Front (Specify Center Capacity)	1	19-18	Leg, Head End Cabinet	
19- 7	Screw	Var. No.	19-19	Washer	
19- 8	Cover, Quick Change Box	1	19-20	Screw (Tail End Leg to Bed)	
19- 9	Washer	3	19-21	Shim	
19-10	Screw (Head End Leg to Bed)	3	19-22	Leg, Tail End Cabinet	
19-11	Shim	3	19-23	Spacer	
19-12	Cover, Feed Gear	1			

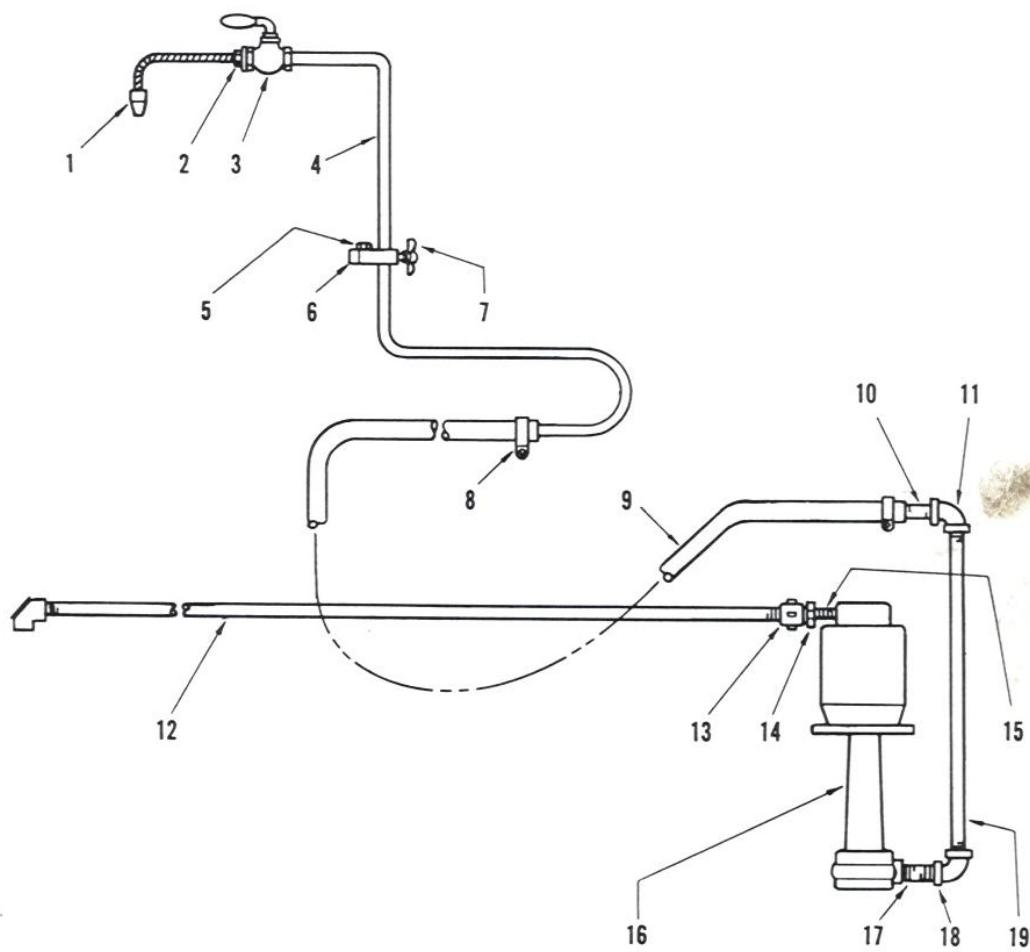


FIGURE 20

COOLANT PUMP WITH PIPING

Key No.	Part Name	Qty.
20-1	Spout, "Stay Put" Flexible Coolant.....	1
20-2	Bushing, Reducing	1
20-3	Cock, Stop	1
20-4	Pipe, Coolant	1
20-5	Screw, Hex Head Cap	1
20-6	Bracket	1
20-7	Screw, Wing	1
20-8	Clamp, Hose	2
20-9	Hose, Rubber (Cut to Suit)	1
20-10	Nipple, 3/8".....	1
20-11	Elbow, 90°, 3/8"	1
20-12	Conduit, 1/2" (Specify Length)	1
20-13	Union, Conduit	1
20-14	Locknut	1
20-15	Nipple	1
20-16	Pump, Ruthman (Specify H.P., Voltage and Cycles)	1
20-17	Nipple, 1/2" nom. x 2"	1
20-18	Elbow, 90° Reducing, 1/2" x 3/8"	1
20-19	Nipple, Pipe, 3/8" x 20"	1

IMPORTANT - Include serial number of your lathe when
ordering repair parts.

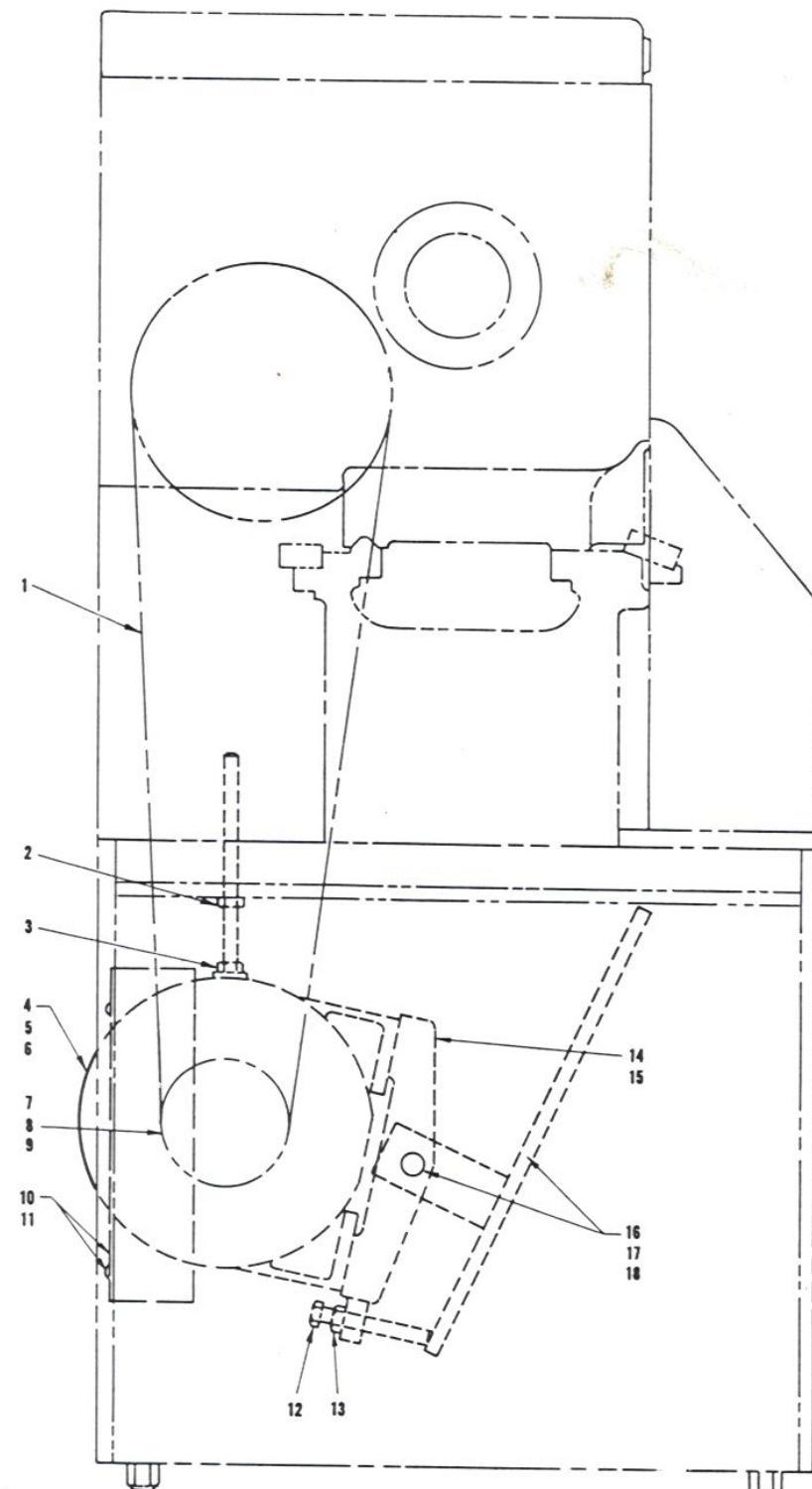


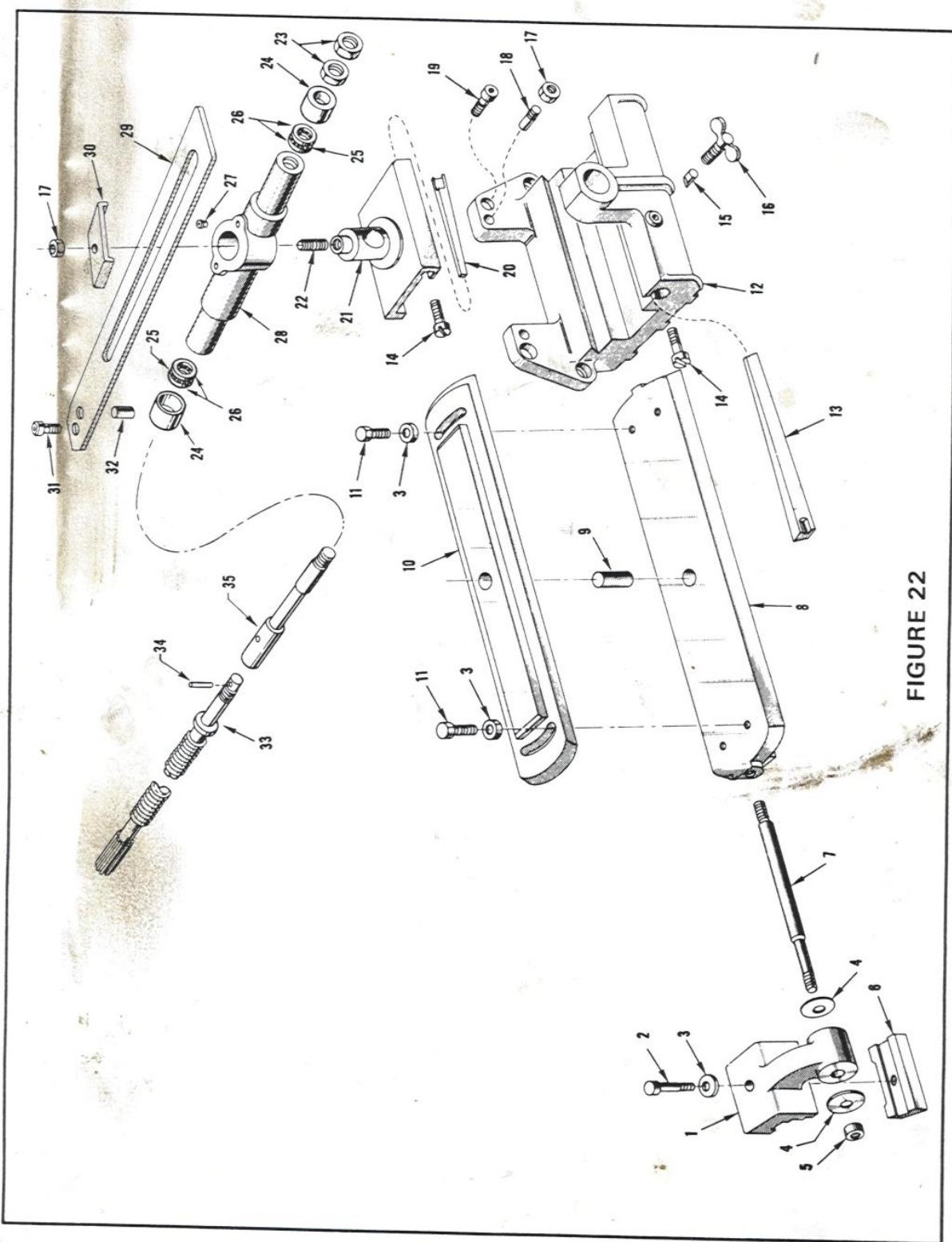
Figure 21

MOTOR DRIVE & MOUNTING ASSEMBLY

Key No.	Part Name	Qty.
21-1	V-Belt, Gates	3
21-2	Nut	1
21-3	Bolt	1
21-4	Motor - A-C New Nema Frame Number Specify Current, Voltage, Horsepower, Phase and Cycle	1
21-5	Washer	4
21-6	Screw	4
21-7	Pulley, Motor Specify Cycle, Horsepower and Speed Range Desired	1
21-8	Key	1
21-9	Screw, Set	1
21-10	Guard	1
21-11	Screw, Round Head	2
21-12	Screw	1
21-13	Nut	1
21-14	Plate, Motor	1
21-15	Screw, Set	1
21-16	Shaft	1
21-17	Pin, Cotter	2
21-18	Arm, Bracket Holder	1

IMPORTANT — Include serial number of your lathe when
ordering repair parts.

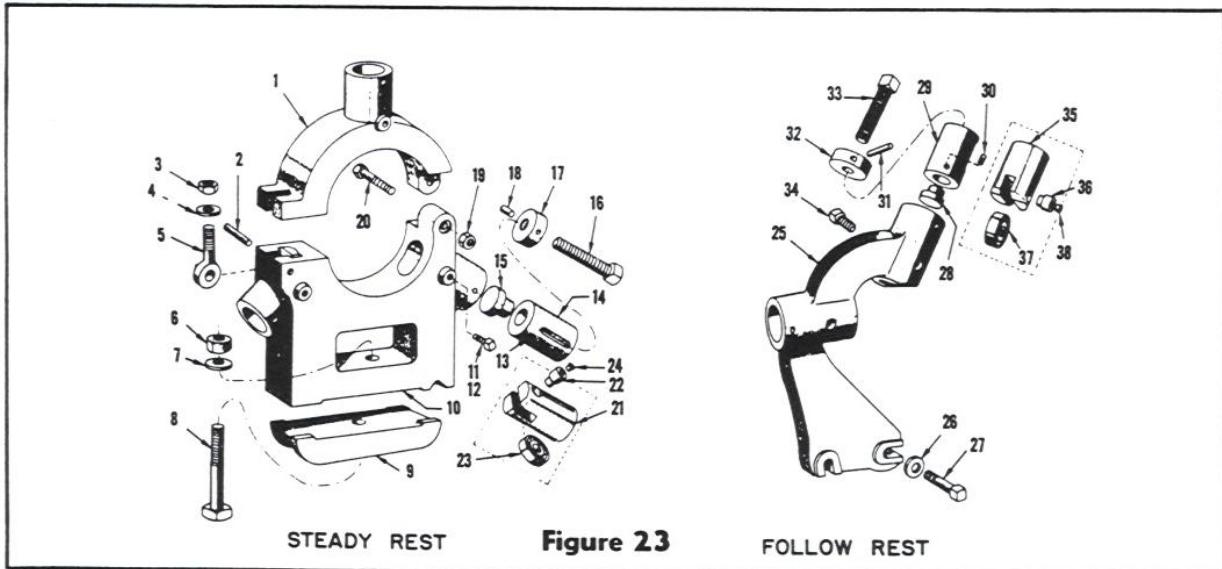
FIGURE 22



TAPER ATTACHMENT

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
22- 1	Bracket, Bed.	1	22-27	Oiler	2
22- 2	Screw, Hex Hd. Cap	1	22-28	Shoe, Carriage	1
22- 3	Washer	3	22-29	Bar, Taper Attachment Draw	1
22- 4	Washer	2	22-30	Plate, Guide Bar Clamp	1
22- 5	Nut, Hex	1	22-31	Screw, Sock Hd. Cap	1
22- 6	Clamp, Bed Bracket	1	22-32	Pin	1
22- 7	Rod, Bed Bracket Clamp	1	22-33	Screw, Cross Feed (English)	1
22- 8	Slide, Taper Attachment	1	22-34	Pin	1
22- 9	Plug, Guide Bar Swivel	1	22-35	Extension	1
22-10	Bar, Guide (English)	1			
	Bar, Guide (Metric)	1			
22-11	Screw, Hex Cap	2			
22-12	Bracket, Taper Attachment Slide	1			
*22-13	Gib, Slide	1			
22-14	Screw, Gib	4			
22-15	Plug, Slide Gib 1-2	1			
22-16	Screw, Thumb	1			
22-17	Nut, Hex	3			
22-18	Pin, Draw.	2			
22-19	Screw, Sock. Hd. Cap	4			
*22-20	Gib, Guide Bar Shoe	1			
22-21	Shoe, Guide Bar	1			
22-22	Stud, Carriage Shoe	1			
22-23	Nut, Hex Lock	2			
22-24	Collar, Cross Feed Screw	2			
22-25	Bearing	2			
22-26	Bearing, Thrust	4			

*Gibs are furnished slightly oversize. Customer to fit and cut to suit on assembly.



STEADY REST CAPACITY

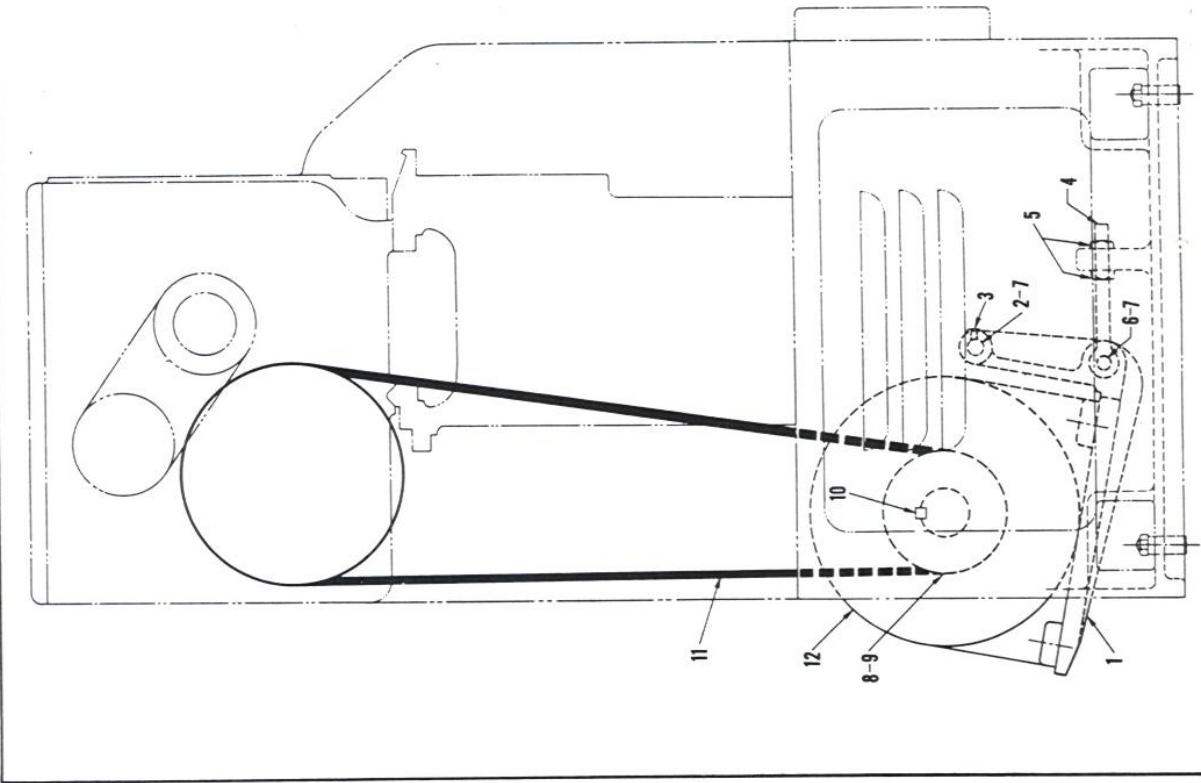
15" 1/2" to 4"
19" 1/2" to 6"

FOLLOW REST CAPACITY

15" 1/2" to 2 3/4"
19" 1/2" to 3 3/4"

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
23- 1	Top, Steady Rest	1	23-20	Screw, Hex Cap.	1
23- 2	Pin, Straight	1	23-21	Jaw, Roller	3
23- 3	Nut	1	23-22	Stud.	3
23- 4	Washer	1	23-23	Roller	3
23- 5	Bolt, Eye	1	23-24	Oiler	3
23- 6	Nut	1	23-25	Rest, Follow.	1
23- 7	Washer	1	23-26	Washer.	2
23- 8	Bolt, Rough	1	23-27	Screw, Hex Cap.	2
23- 9	Clamp, Steady Rest	1	23-28	Tip, Bronze	2
23-10	Bottom, Steady Rest	1	23-29	Jaw, Follow Rest	2
23-11	Screw, Sq. Hd. Set (Brz. Tip Jaws). . .	3	23-30	Screw, Set	2
23-12	Screw, Sq. Hd. Set (Roller Jaws) . . .	3	23-31	Pin, Straight.	4
23-13	Screw, Set	3	23-32	Collar, Jaw Adj. Screw	2
23-14	Jaw, Steady Rest	3	23-33	Screw, Sq. Hd. Set.	2
23-15	Tip, Bronze	3	23-34	Screw, Sq. Hd. Set.	2
23-16	Screw, Sq. Hd. Set.	3	23-35	Jaw, Roller	2
23-17	Collar, Jaw Adj. Screw	3	23-36	Stud.	2
23-18	Pin, Straight.	6	23-37	Roller	2
23-19	Nut	1	23-38	Oiler	2

IMPORTANT—Include serial number of your lathe when ordering repair parts.



Key No.	Part Name	Qty.
24- 1	Plate, Motor	1
24- 2	Shaft, Motor Plate	1
24- 3	Screw, Set	2
24- 4	Bolt, Eye	1
24- 5	Nut, Hex	2
24- 6	Pin, Link	1
24- 7	Cotter Pin (3/4" Long)	2
24- 8	Pulley, Motor 3" P.D. 1-1/8"	1
24- 9	Hole (New nema frame) for 50 Cy. 3 & 5 HP & 25 Cy. 3 HP Pulley, Motor 3" P.D. 1-1/8" Hole (New nema frame) for 50 Cy. 3 & 5 HP & 25 Cy. 3 HP Pulley, Motor 3" P.D. 1-1/8" Hole (New nema frame) for 60 Cy. 3 & 5 HP Pulley, Motor 3" P.D. 1-1/8" Hole (New nema frame) for 25 Cy. 5 HP	1
24-10	Key	1
24-11	V-Belt, Gates	4
24-12	Motor, A-C New Nema Frame Number (Specify current voltage, horsepower & cycle to suit order).	1

IMPORTANT—Include serial number of your lathe when ordering repair parts.

MOTOR DRIVE

SLIDING BED GAP LATHE ONLY

Figure 24

GEARED FEED, TRAVERSE DRIVE AND SWITCH CONTROL ASSEMBLIES
19" SLIDING BED GAP

Key No.	Part Name	Qty.	Key No.	Part Name	Qty.
25-1	Spacer	1	25-72	Brg.	1
25-2	Plate, Bottom Bed Bracket	1	25-73	Plug.	1
25-3	Screws, Soc. Hd. Cap.	14	25-74	Lever, Upper	1
25-4	Screw, Soc. Hd. Cap.	1	25-75	Key	1
25-5	Screw, Soc. Hd. Cap.	5	25-76	Ball, Brg.	1
25-6	Screw, Soc. Hd. Cap.	3	25-77	Ball, Brg.	1
25-7	Screw, Soc. Hd. Cap.	1	25-79	Ring, Snap Truarc	1
25-8	Screw, Soc. Hd. Cap.	2	25-80	Lever, Lower	1
25-9	Screw, Soc. Hd. Cap.	4	25-81	Gear, Drive Shaft	1
25-10	Screw, Soc. Hd. Cap.	2	25-82	Stud, Idler	1
25-11	Pin, Taper	2	25-83	Race, Inner	1
25-12	Pin, Taper	1	25-84	Brg.	1
25-13	Nut	2	25-85	Gear, Idler	1
25-14	Pin,	1	25-86	Stud, Feed Rod Drive	1
25-15	Pin, Taper	1	25-87	Race, Inner	1
25-16	Pin, Taper	1	25-88	Brg.	1
25-17	Pin, Taper	1	25-89	Gear, Feed Rod Drive.	1
25-18	Pin, Taper	3	25-90	Plug, Expansion.	1
25-19	Pin, Taper	4	25-91	Collar	1
25-20	Gear, Idler	1	25-93	Nut	5
25-21	Plug, Idler Gear	1	25-95	Shoe, Shifter.	1
25-22	Brg., Torrington	1	25-96	Lever, Shifter	1
25-23	Gear, Drive Shaft Feed	1	25-97	Knob	1
25-24	Washer.	1	25-98	Sleeve	1
25-25	Nut	1	25-99	Spring (Cut to Suit).	1
25-26	Pin, Cotter	1	25-100	Plunger	1
25-27	Pin, Cotter	9	25-101	Handle, Feed Rev.	1
25-29	Pin, Link	4	25-102	Shaft, Shifter.	1
25-30	Lever, Switch Control.	1	25-103	Screw	2
25-31	Washer.	1	25-104	Screw	1
25-32	Screw, Set	2	25-105	Clamp, Brg.	1
25-33	Screw	1	25-106	Pin, Draw.	3
25-34	Screw, Set	4	25-107	Oiler	1
25-35	Screw, Set	2	25-108	Pipe, Plug	1
25-36	Screw, Set	2	25-109	Screw	2
25-37	Gear, Switch Control	1	25-110	Plug.	4
25-39	Rod, Control	1	25-111	Link.	1
25-40	Spacer	1	25-112	Cover, Switch	1
25-41	Collar, Brg.	1	25-113	Plug, Shoulder	1
25-42	Sleeve, Drive Shaft	1	25-114	Oiler	1
25-43	Brg., Ball Duplex	1	25-115	Rod, Feed (Spec. Bed Length).	1
25-44	Shaft, Feed Drive (Spec. Bed Length)	1	25-116	Stud, Brkt., Swivel (W/O Apron Control)	1
25-45	Seal, Oil	1	25-117	Stud, Brkt., Swivel (W Apron Control)	1
25-46	Cover, Brg.	1	25-118	Bracket, Drive Shaft Support	1
25-47	Key	3	25-119	Bracket, Trav. Unit	1
25-48	Stud, Idler	1	25-120	Box, Back.	1
25-49	Collar	1	25-121	Plug.	2
25-50	Washer.	1	25-122	Brkt., Drive Shaft End	1
25-51	Screw, Hex. Hd. Cap.	1	25-123	Lug, Stop Collar	1
25-52	Brg., Torrington	2	25-124	Collar, Stop	1
25-53	Pinion, Feed Drive.	1	25-125	Collar, Soft	2
25-54	Seal, Oil	1	25-126	Brkt., Lower	1
25-55	Brkt., Bottom Bed Feed	1	25-127	Handle, Upper Nut	1
25-56	Plate, Top Bed Brkt	1	25-128	Nut, Upper Half	1
25-57	Brkt., Top Bed Feed	1	25-129	Nut, Lower Half	1
25-58	Link.	1	25-130	Stud, Nut Swivel.	1
25-59	Brg.	1	25-131	Rod, Upper Control (Spec. Bed Length)	1
25-60	Race, Brg.	1	25-132	Cover, Slip Gear	1
25-61	Race, Brg.	1	25-133	Screws, Binding Hd.	6
25-62	Pilot, Brg. Guide	1	25-134	Screws, Binding Hd.	2
25-63	Brg., Needle Orange	1	25-135	Screw, Binding Hd.	1
25-64	Pin, Straight	1	25-136	Shaft, Gear	1
25-65	Screw, Lead (Spec. Bed Length)	1	25-137	Bracket, Switch.	1
25-66	Seal, Oil	1	25-138	Crank, Shifter	1
25-67	Ball.	2	25-139	Gear, 32T-16P	1
25-69	Spring, Feed Rod Dr. Collar	1	25-140	Gear, 16T-16P	1
25-70	Collar, Feed Drive.	1	25-141	Cover, Switch	1
25-71	Race, Inner	1	25-142	Pin, Taper	1

IMPORTANT — Include serial number of your lathe when ordering repair parts.

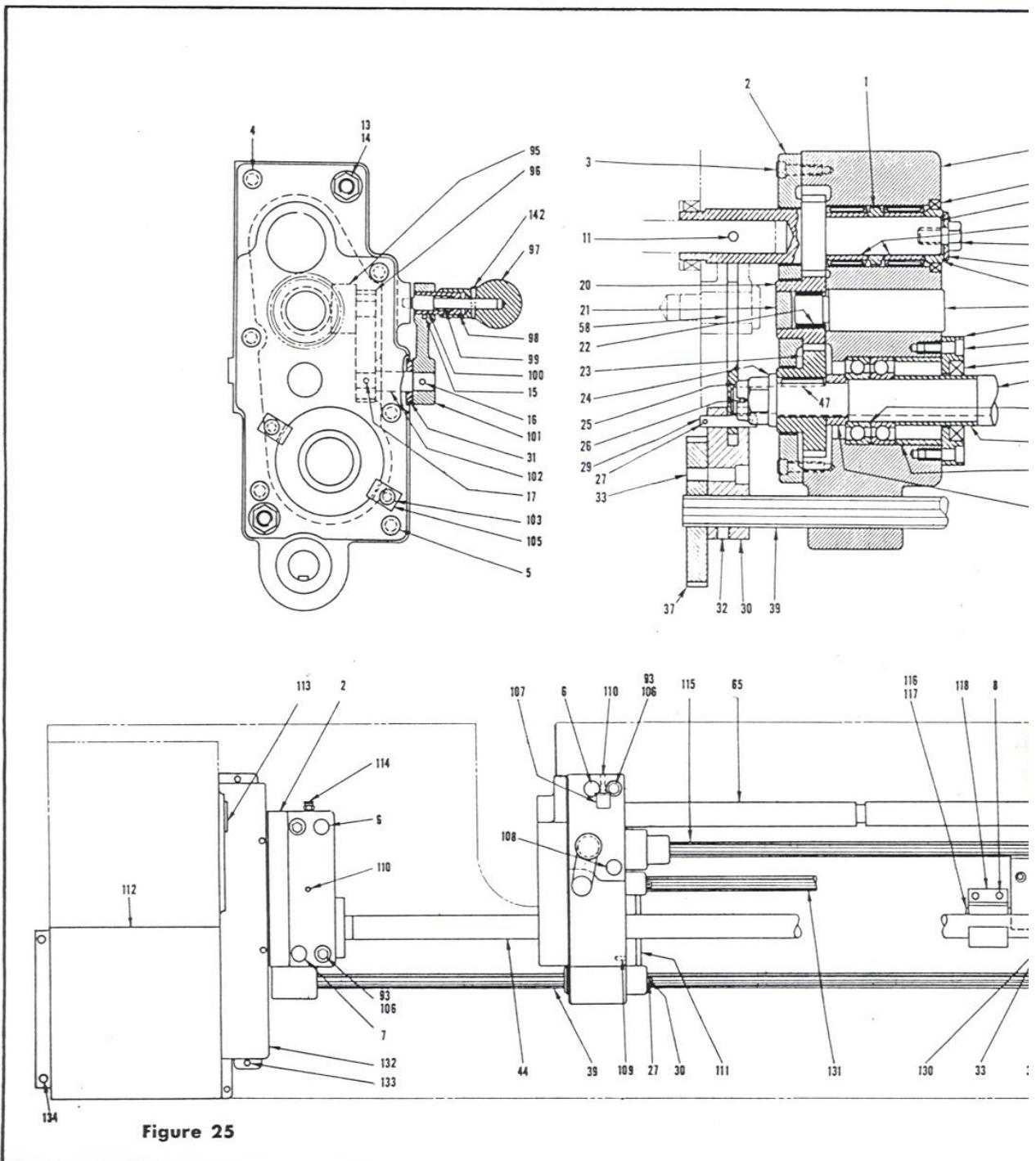
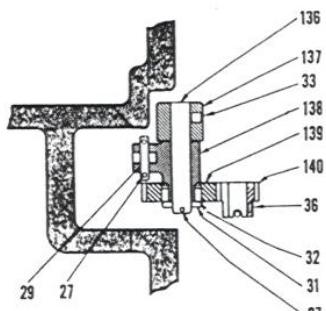
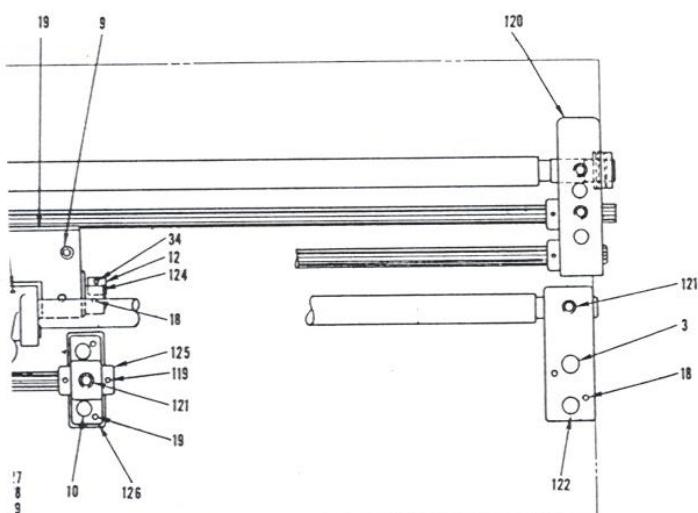
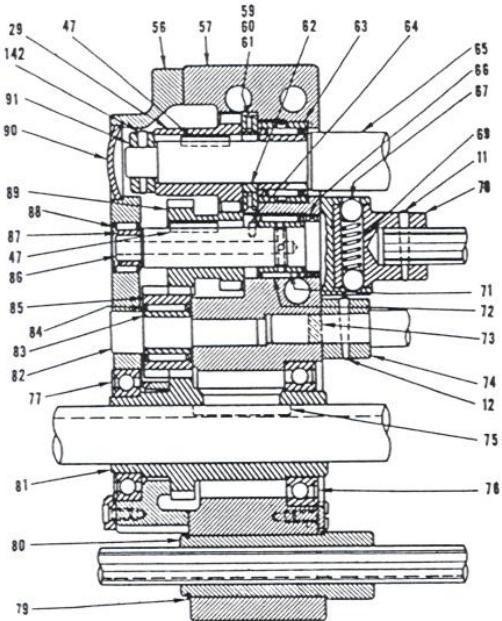
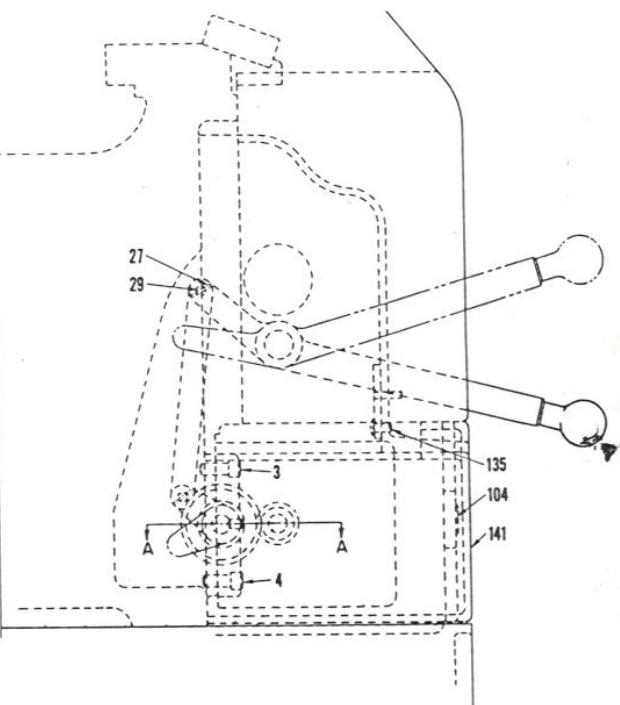


Figure 25



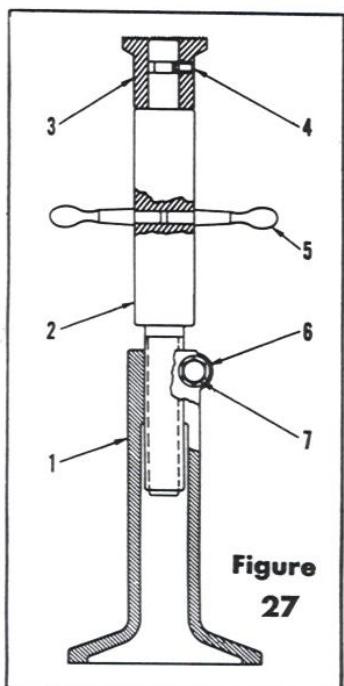
SECTION A-A



BED, PAN, LEGS & HEAD END COVER
SLIDING BED GAP LATHES

Key No.	Part Name	Q'ty.	Key No.	Part Name	Q'ty.
26- 1	Screw, (S. B. G. - Specify Bed Length). Bed, Bottom (S. B. G. - Specify Length)	Var. No. 1	26-20	Screw, Leveling.	.
26- 2	Bed, (P. G. G. - Specify Length) Not Shown	1	26-21	Pan, (Specify Center Capacity).	.
26- 3	Bolt, S. B. G.	1	26-22	Leg, Tail End Cabinet.	.
26- 4	Nut, S. B. G.	1	26-23	Screw	.
26- 5	Washer, S. B. G.	1	26-24	Magnet, Alnico	.
26- 6	Clamp, S. B. G.	1	26-25	Screw, Brass Machine Flat Head	.
26- 7	Screw	1	26-26	Door	.
26- 8	Pin, Taper	1	26-27	Plug, Pipe	.
26- 9	Rack, Specify Center Capacity	1	26-28	Clamp, Pump Plate	.
26-10	Cover, Head End Leg	1	26-29	Plate, Pump	.
26-11	Screw	1	26-30	Screw, Hex Head Cap	.
26-12	Screw	3	26-31	Screw	.
26-13	Screw	2	26-32	Block, Gap (P. B. G. only) Not Shown.	.
26-14	Washer	3	26-33	Oiling Instruction Plate	.
26-15	Screw	7	26-34	Shear, Rear (Specify Center Capacity)	.
26-16	Magnet, Alnico Carbonyl	1	26-35	Cover, Feed Gear	.
26-17	Screw, Brass Machine Flat Head	1	26-36	Screw, Socket Head Cap	.
26-18	Door	1	26-37	Shear, Front (Specify Center Capacity)	.
26-19	Leg, Head End Cabinet	1	26-38	Screw, (S. B. G. - Specify Bed Length)	.
		1	26-39	Bed, Top (S. B. G. - Specify Length)	.
				Var. No. 1	

IMPORTANT—Include serial number of your lathe when ordering repair parts.



BED JACK UNIT

Sliding Bed Gap Lathe Only

Key No.	Part Name	Qty.
27-1	Jack Base	1
27-2	Jack Screw	1
27-3	Jack Screw Cap	1
27-4	Set Screw	1
27-5	Ball Handle	2
27-6	Washer	1
27-7	Screw	1

IMPORTANT—Include serial number of your lathe when ordering repair parts.

**HEAVY DUTY TAILSTOCK
FOR 19"**

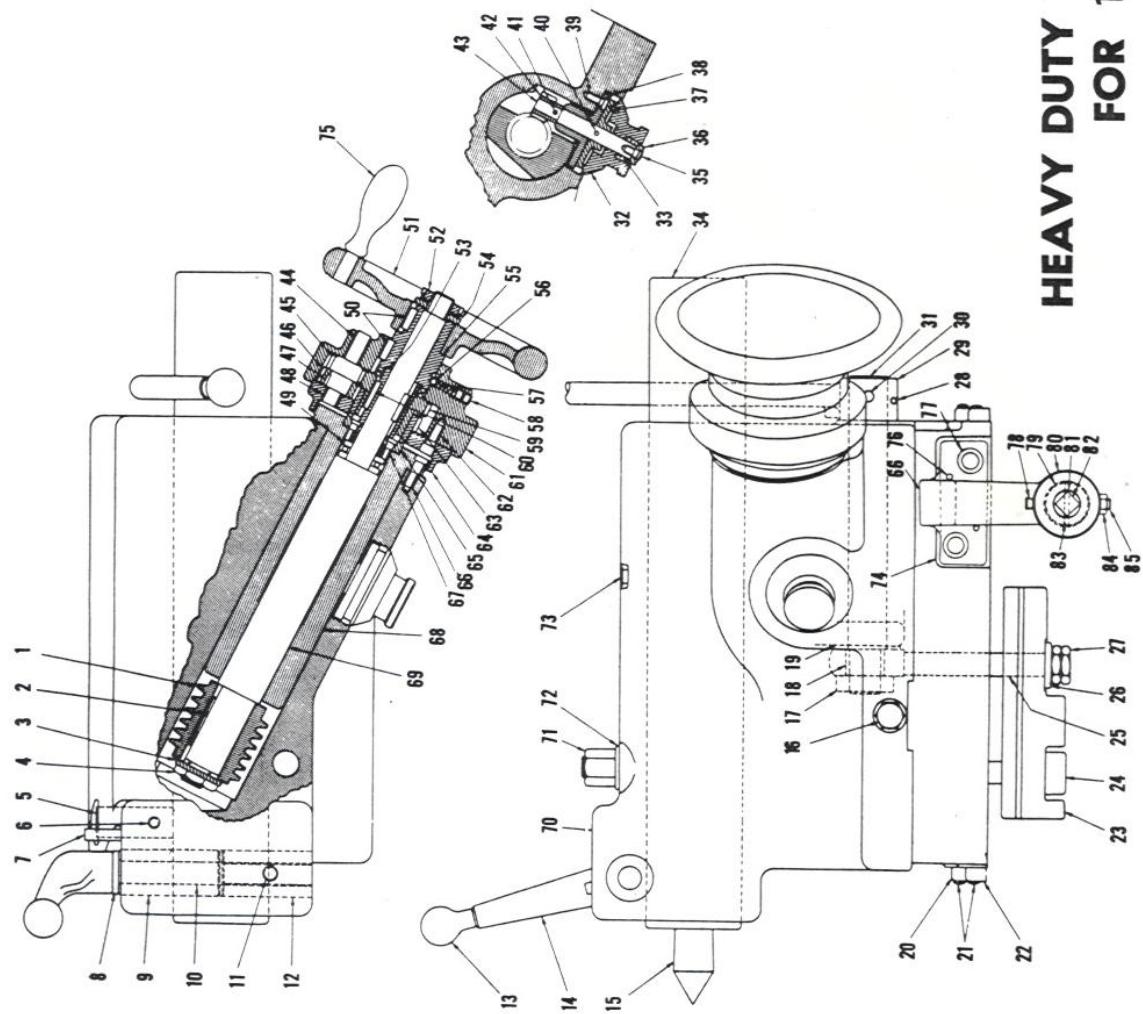


Figure 28

HEAVY DUTY TAILSTOCK FOR 19"

KEY NO.	PART NAME	QUANTITY	KEY NO.	PART NAME	QUANTITY
28-1	Worm	1	28-43	Shaft	1
28-2	Key	1	28-44	Bearing	1
28-3	Washer	1	28-45	Gear	1
28-4	Nut	1	28-46	Gear	1
28-5	Plug	1	28-47	Pin	1
28-6	Screw	3	28-48	Bearing	3
28-7	Pin	1	28-49	Bearing	1
28-8	Washer	1	28-50	Key	1
28-9	Bushing	1	28-51	Handwheel	2
28-10	Stud	1	28-52	Washer & Nut	1
28-11	Screw	1	28-53	Bush	1
28-12	Bushing	1	28-54	Collar	1
28-13	Ball	2	28-55	Bush	1
28-14	Handle	1	28-56	Ball	1
28-15	Center	1	28-57	Spring	1
28-16	Screw	2	28-58	Screw	2
28-17	Screw	1	28-59	Gear	1
28-17A	Nut	1	28-60	Key	1
28-18	Bearing	1	28-61	Carrier	1
28-19	Spacer	1	28-62	Screw	4
28-20	Wiper	2	28-63	Gear	1
28-21	Screw	4	28-64	Plate	1
28-22	Wiper	2	28-65	Clutch	1
28-23	Clamp	1	28-66	Bracket	1
28-24	Bolt	1	28-67	Screw	4
28-25	Eyebolt	1	28-68	Bush	1
28-26	Washer	1	28-69	Shaft	1
28-27	Nut	2	28-70	Top	1
28-28	Screw	1	28-71	Nut	1
28-29	Handle	1	28-72	Washer	1
28-30	Pin	1	28-73	Oilers	2
28-31	Shaft	1	28-74	Bottom	1
28-32	Dial	1	28-75	Handle	1
28-33	Spring	1	28-76	Pin	2
28-34	Spindle	1	28-77	Screw	2
28-35	Screw	1	28-78	Oiler	1
28-36	Washer	1	28-79	Bushing	1
28-37	Clutch	1	28-80	Collar	1
28-38	Bushing	1	28-81	Pinion	1
28-39	Screw	3	28-82	Crank	1
28-40	Pin	1	28-83	Pin	1
28-41	Pin	1	28-84	Nut	1
28-42	Worm	1	28-85	Screw	1

IMPORTANT—Include serial number of your lathe when ordering repair parts.